

NAVFAC
Naval Facilities Engineering Command

ENGINEERING SERVICE CENTER
Port Hueneme, California 93043-4370

TECHNICAL REPORT

TR-2243-ENV


FINAL REPORT FOR THE USE OF WETTING AGENTS/FUME SUPPRESSANTS FOR MINIMIZING THE ATMOSPHERIC EMISSIONS FROM HARD CHROMIUM ELECTROPLATING BATHS

by

Kathleen Paulson, NFESC
Craig Matzdorf, NAVAIR
Stephen Schwartz, Versa Corporation

March 2004

Approved for public release; distribution is unlimited.

 Printed on recycled paper

| REPORT DOCUMENTATION PAGE | | | | | <i>Form Approved OMB No. 0704-0811</i> | |
|--|--|-------------------------|-------------------------------------|--------------------------------|--|--|
| The public reporting burden for this collection of information is estimated to average 1 hour per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing the burden to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports (0704-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information, if it does not display a currently valid OMB control number. | | | | | | |
| PLEASE DO NOT RETURN YOUR FORM TO THE ABOVE ADDRESS. | | | | | | |
| 1. REPORT DATE (DD-MM-YYYY) | | 2. REPORT TYPE Final | | 3. DATES COVERED (From – To) | | |
| 4. TITLE AND SUBTITLE FINAL REPORT FOR THE USE OF WETTING AGENTS/FUME SUPPRESSANTS FOR MINIMIZING THE ATMOSPHERIC EMISSIONS FROM HARD CHROMIUM ELECTROPLATING BATHS | | | | 5a. CONTRACT NUMBER | | |
| | | | | 5b. GRANT NUMBER | | |
| | | | | 5c. PROGRAM ELEMENT NUMBER | | |
| 6. AUTHOR(S) Kathleen Paulson, Craig Matzdorf, and Stephen Schwartz | | | | 5d. PROJECT NUMBER | | |
| | | | | 5e. TASK NUMBER | | |
| | | | | 5f. WORK UNIT NUMBER | | |
| 7. PERFORMING ORGANIZATION NAME(S) AND ADDRESSES Commanding Officer NFESC 1100 23 rd Avenue Port Hueneme, CA 93043 Commander NAVAIR Patuxent River, MD 20670 | | | | | 8. PERFORMING ORGANIZATION REPORT NUMBER TR-2243-ENV | |
| 9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES) Environmental Security Technology Certification Program 901 North Stuart Street, Suite 303 Arlington, VA 22203 | | | | | 10. SPONSOR/MONITORS ACRONYM(S) ESTCP | |
| | | | | | 11. SPONSOR/MONITOR'S REPORT NUMBER(S) | |
| 12. DISTRIBUTION/AVAILABILITY STATEMENT | | | | | | |
| 13. SUPPLEMENTARY NOTES | | | | | | |
| 14. ABSTRACT This project demonstrates that a “third” generation wetting agent/fume suppressant (WA/FS) chemical additive to hard chromium electroplating baths reduces hexavalent chromium airborne emissions to the environment and reduces employee occupational exposures in the electroplating shop. While emissions are important, maintaining material quality for tactical equipment is paramount, and the WA/FS has no negative effect on electroplating quality or basis metals. Further, once added to the electroplating bath, the WA/FS does not measurably degrade over a period of time. Also, the project demonstrates the use of WA/FS during normal, full-scale plating operations. | | | | | | |
| 15. SUBJECT TERMS Electroplating, hexavalent chromium, total chromium, source emissions, occupational health, engineering (area) sample | | | | | | |
| 16. SECURITY CLASSIFICATION OF: a. REPORT U b. ABSTRACT U c. THIS PAGE U | | | 17. LIMITATION OF ABSTRACT U | 18. NUMBER OF PAGES 238 | 19a. NAME OF RESPONSIBLE PERSON 19b. TELEPHONE NUMBER (include area code) | |



**ESTCP
FINAL REPORT**

For

**THE USE OF WETTING AGENTS/FUME
SUPPRESSANTS
FOR MINIMIZING THE ATMOSPHERIC EMISSIONS
FROM
HARD CHROMIUM ELECTROPLATING BATHS**

**Naval Facilities Engineering Service Center
Naval Occupational Safety and Health
1100 23rd Street,
Port Hueneme, CA 93043**

December 2003

TABLE OF CONTENTS

| | | |
|---------|--|----|
| 1.0 | Introduction..... | 1 |
| 1.1 | Background Information..... | 1 |
| 1.2 | Objectives of the Demonstration | 1 |
| 1.3 | Regulatory Issues | 3 |
| 1.4 | Previous Testing of the Technology | 4 |
| 2.0 | Technology Description..... | 6 |
| 2.1 | Description..... | 6 |
| 2.1.1 | Theory | 6 |
| 2.1.2 | Process Description..... | 7 |
| 2.1.2.1 | Installation and Operation Requirements..... | 7 |
| 2.1.2.2 | Design Criteria..... | 8 |
| 2.1.2.3 | Process Schematic and Description | 9 |
| 2.2 | Strengths, Advantages, and Weaknesses | 9 |
| 2.2.1 | Strengths | 9 |
| 2.2.2 | Weaknesses | 10 |
| 2.3 | Factors Influencing Cost and Performance..... | 11 |
| 2.3.1 | Factors Influencing Cost..... | 11 |
| 2.3.2 | Factors Influencing Performance | 12 |
| 3.0 | Site/Facility Description | 13 |
| 3.1 | Background..... | 13 |
| 3.2 | Site/Facility Characteristics | 14 |
| 3.2.1 | Naval Aviation Depot, NADEP Cherry Point | 14 |
| 3.2.2 | Air Logistics Center, Oklahoma City (Tinker AFB) | 15 |
| 3.2.3 | Naval Air Depot, North Island..... | 15 |
| 4.0 | Demonstration Approach..... | 16 |
| 4.1 | Performance Objectives..... | 16 |
| 4.2 | Physical Setup and Operation | 16 |
| 4.3 | Sampling Procedures | 17 |
| 4.4 | Analytical Procedures | 20 |
| 5.0 | Performance Assessment | 22 |
| 5.1 | Performance Data..... | 22 |
| 5.1.1 | Surface Tension | 22 |
| 5.1.2 | Stack Emissions Data..... | 22 |
| 5.1.2.1 | WA/FS Effectiveness and Level of Compliance | 26 |
| 5.1.2.2 | Hexavalent Versus Total Chromium | 26 |
| 5.1.2.3 | The Influence of Exhaust Volume and Velocity..... | 27 |
| 5.1.3 | Industrial Hygiene (IH) Data | 28 |
| 5.1.4 | Mechanical Quality Data | 30 |
| 5.1.4.1 | Hydrogen Embrittlement | 30 |
| 5.1.4.2 | Hardness | 31 |

| | | |
|---------|---|----|
| 5.1.4.3 | Porosity | 32 |
| 5.1.4.4 | Adhesion | 35 |
| 5.1.4.5 | Thickness | 36 |
| 5.1.4.6 | Fatigue | 36 |
| 5.1.4.7 | Material Effects of Fumetrol 140- Conclusion | 37 |
| 5.1.5 | Other Data | 37 |
| 5.1.5.1 | Perfluorooctyl Sulfonate (PFOS) Releases to the Environment..... | 37 |
| 5.1.5.2 | Concentration of Chromium Plating Bath Constituents..... | 38 |
| 5.2 | Technology Comparison | 39 |
| 6.0 | Cost Assessment | 74 |
| 6.1 | Cost Performance..... | 74 |
| 6.2 | Cost Comparison to Conventional and Other Technologies..... | 81 |
| 7.0 | Regulatory Issues | 84 |
| 8.0 | Technology Implementation | 86 |
| 8.1 | DOD Need | 86 |
| 8.2 | Transition | 86 |
| 8.3 | Toxicology..... | 86 |
| 9.0 | Lessons Learned..... | 87 |
| 9.1 | Bath Maintenance Effects Surface Tension | 87 |
| 9.2 | Other Observations | 87 |
| 10.0 | References..... | 88 |

APPENDICES:

| | |
|--|-----|
| A - Points of Contact..... | A-1 |
| B - Data Archiving and Demonstration Plan | B-1 |
| C - Photographs..... | C-1 |
| D - Testing and Scheduling Tables..... | D-1 |
| E - Forms and Related Documents Used for the Collection of Field Data..... | E-1 |
| F - Fatigue Test Methodology and Specimen Specifications | F-1 |
| G - Alternative Industrial Hygiene Sampling Results | G-1 |
| H -Hydrogen Embrittlement Documentation..... | H-1 |
| I - Toxicology Reviews | I-1 |

LIST OF TABLES

| | | |
|-----|--|----|
| 1-1 | USEPA Standards for Chromium Plating and Anodizing Baths | 4 |
| 2-1 | Surface Tension Monitoring Protocol | 8 |
| 5-1 | Summary of Chromium Concentrations in Stack Emissions..... | 24 |
| 5-2 | Influence of Exhaust Parameters on Emissions Concentration | 27 |
| 5-3 | Industrial Hygiene Sampling Data..... | 29 |
| 5-4 | Average Fracture Strengths (Fracture Percent) for RSL Notched Round Bars | 31 |
| 5-5 | Hardness Test..... | 32 |
| 5-6 | Average Thicknesses of Hard Chromium Coatings (mils) | 36 |
| 5-7 | Perfluorooctyl Sulfonates (PFOS) Analyses..... | 38 |
| 6-1 | Costs of Implementing and Using WA/FS Pollution Prevention Technology at Existing Facilities..... | 75 |
| 6-2 | Analysis of Emissions Data and Projected Cost Savings From Use of Fume Suppressant..... | 79 |
| 6-3 | Costs of Implementing and Using WA/FS Pollution Prevention Technology at New Facilities | 80 |
| 6-4 | Summary of Annual Savings When Using WA/FS | 83 |

LIST OF FIGURES

| | | |
|-----|--|----|
| 2-1 | Process Schematic..... | 9 |
| 5-1 | Bar Chart of: NADEP Cherry Point Total Chromium Emissions Concentration..... | 25 |
| 5-2 | Bar Chart of: Tinker AFB Total Chromium Emissions Concentration | 25 |
| 5-3 | Notched Round Bar for Hydrogen Embrittlement Testing..... | 31 |
| 5-4 | Porosity test of hard chromium from tank without Funetrol 140 NADEP (NADEP Cherry Point)..... | 33 |
| 5-5 | Porosity test of hard chromium from tank with Fumetrol 140 NADEP (NADEP Cherry Point..... | 34 |
| 5-6 | Porosity test of hard chromium from tank with Fumetrol 140 NADEP (North Island)..... | 35 |
| 5-7 | Adhesion specimens subjected to bend-to-break test..... | 36 |

LIST OF ACRONYMS

| | |
|--------|---|
| AFB | - Air Force Base |
| AIH | - |
| ALC | - Air Logistics Center |
| AMS | - Aerospace Material Specification |
| ASTM | - American Society for Testing Materials |
| APCD | - Air Pollution Control Devices |
| ASTM | - International – formerly American Society for Testing Materials |
| CAE | - Clean Air Engineering |
| CNO | - Chief of Naval Operations |
| CFR | - Code of Federal Regulations |
| CIHL | - Consolidated Industrial Hygiene Laboratory |
| DOD | - Department of Defense |
| ESTCP | - Environmental Security Technology Certification Program |
| FAA | - Federal Aviation Authority |
| HVOF | - High Velocity Oxy-Fuel |
| IH | - Industrial Hygiene |
| MACT | - Maximum Achievable Control Technology |
| MAPCO | - |
| MSDS | - Material Safety Data Sheet |
| NAS | - Naval Air Station |
| NADEP | - Naval Aviation Depot |
| NAVAIR | - Naval Air Command |
| NAVSEA | - Naval Sea Systems Command |
| NEPMU | - Navy Environmental and Preventative Medicine Unit |
| NESHAP | - National Emission Standard for Hazardous Air Pollutants |
| NFESC | - Naval Facilities Engineering Service Center |
| NIOSH | - National Institute of Safety and Health |
| NRMRL | - National Risk Management Research Laboratory |
| OEM | - Organelle Equipment Manufacturer |
| OFS | - Organic Fluorosulfanates |
| OSHA | - Occupational Safety and Health Administration |
| PEL | - Permissible Exposure Limit |
| PES | - Pacific Environmental Services |
| PFOS | - Perfluorooctane Sulfonates |
| QAQPS | - Office of Air Quality Planning and Standards |
| R&D | - Research and Development |
| RMRL | - Risk Management Research Laboratory |
| RTI | - Research Triangle Institute |
| SAE | - Society of Automotive Engineers |
| SIBS | - Spark Induced Breakdown Spectrometry |
| USAF | - United States Air Force |
| USEPA | - United States Environmental Protection Agency |
| USN | - United States Navy |
| WA/FS | - Wetting Agent Fume Suppressant |

ACKNOWLEDGEMENTS

Support from the following organizations and persons are gratefully acknowledged:

- Kathleen (Kappy) Paulson - Naval Facilities Engineering Service Center, Port Hueneme, California – Project Manager
- Stephen Schwartz - Versar, Inc., Springfield, Virginia – Environmental testing and Project Coordination
- Craig Matzdorf - Naval Air Command, Aerospace Materials Division Patuxent, Maryland – Material Testing Coordination
- T. David (Dave) Ferguson - EPA Risk Management Research Lab, Cincinnati, Ohio
Regulatory and Sampling Advice
- Glen Graham - Air Logistics Center, Tinker Air Force Base, Oklahoma City, Oklahoma - Coordination of Sampling Activities at Tinker AFB
- Jesse Garman - Naval Air Depot, NADEP Cherry Point, North Carolina –
Coordination of Sampling Activities at NADEP Cherry Point
- Ernie Shiwanov - Naval Air Depot, North Island, San Diego, California – Data on
Activities at North Island

Funding by the U.S. Environmental Security Technology Certification Program (ESTCP) is also gratefully acknowledged.

1. Introduction

This project demonstrates that a “third” generation wetting agent/fume suppressant (WA/FS) chemical additive to hard chromium electroplating baths reduces hexavalent chromium airborne emissions to the environment and reduces employee occupational exposures in the electroplating shop. While emissions are important, maintaining material quality for tactical equipment is paramount, and the WA/FS has no negative effect on electroplating quality or basis metals. Further, once added to the electroplating bath, the WA/FS does not measurably degrade over a period of time. Also, the project demonstrates the use of WA/FS during normal, full-scale plating operations.

1.1 Background Information

Hexavalent chromium is a heavily regulated material by both the United States Environmental Protection Agency (USEPA) and the Occupational Safety and Health Administration (OSHA). During plating operations, the combination of mechanical mixing by aeration and electrolytic activity causes bubbles to be emitted from hexavalent chromium electroplating baths. Mist from the bubbles is then pulled into the exhaust ventilation system, and discharged to the atmosphere (usually after passing through an air pollution control device (APCD) that typically removes over 99 percent of the mist from the exhausted air stream). The relatively small amount of mist that is not captured by the ventilation system is disbursed throughout the shop into worker breathing zones, and eventually deposits on surfaces throughout the shop.

This project examines the use of one WA/FS product (Fumetrol® 140) that reduces the surface tension of the chromium electroplating bath. Reduced surface tension means reduced size of the bubbles produced. Reduced bubble size causes less misting, hence less hexavalent chromium emissions. Therefore, less chromium is exhausted to the APCD, and there are also less fugitive emissions into the plant environment, subsequently reducing employee occupational exposure. Other WA/FS products were considered but not included because their formulations were undergoing changes in the early stages of the project.

WA/FS additives are considered an inexpensive interim solution to compliance with USEPA’s National Emission Standard for Hazardous Air Pollutants (NESHAP) for hexavalent chromium until the Department of Defense (DOD) and others develop alternative technologies that can substitute for hard chromium electroplating. In approximately 30 percent of existing hard chromium plating operations the alternatives in development cannot currently be used. WA/FS will significantly reduce emissions in those operations.

1.2 Objectives of the Demonstration

One project goal is to provide data to the regulatory arm of the USEPA to support the inclusion of WA/FS use as an acceptable alternative to the quantitative NESHAP stack emission standards for hard chromium electroplating. Such an alternative is currently available for *decorative* chromium producers. The project is designed to demonstrate that Fumetrol® 140, a WA/FS, significantly reduces atmospheric emissions during routine, full-scale electroplating operations.

It is intended to show that if surface tension is controlled to 30 dynes/cm or less with WA/FS, then atmospheric emissions from the hard chromium bath exhaust system are likely to comply with the NESHAP emissions limit of 15 micrograms per dry standard cubic meter ($\mu\text{g}/\text{dscm}$), which is the most stringent standard for hard chromium bath emissions (see Table 1-1). This standard is based on control by APCDs (e.g., scrubbers, mesh pad mist eliminators, etc.).

A second objective is to demonstrate that there is a significant reduction in fugitive chromium emissions from the bath (i.e., emissions to the workplace). WA/FS additives are reported to reduce occupational exposures to help ensure compliance with the current Permissible Exposure Level (PEL) of 100 micrograms per cubic meter ($\mu\text{g}/\text{m}^3$) as chromium trioxide (CrO_3), which is equivalent to 52 $\mu\text{g}/\text{m}^3$ as chromium. (However, OSHA has proposed to reduce the exposure to a PEL between 0.5 to 5.0 $\mu\text{g}/\text{m}^3$ as chromium.) In any case, the project is intended to show that there is a significant drop in area emissions, which implies lower occupational exposures.

A third objective is to determine that the WA/FS does not negatively affect the integrity of the electroplating process, the hard chromium coating, or the functional properties of the plated components. Critical properties are fatigue characteristics and embrittlement. Successful evaluation requires that material testing of hard chromium-plated samples produced in baths containing WA/FS perform as well as samples treated in baths without WA/FS.

Testing occurred at Naval Air Depot (NADEP) Cherry Point, North Carolina, and Air Logistics Center (ALC), Oklahoma City, Oklahoma (Tinker Air Force Base (AFB)) from the summer of 2000 through the summer of 2001. Also, relevant data were gathered from NADEP North Island, San Diego, California. North Island's electroplating shop already uses Fumetrol® 140. Since a baseline without WA/FS could not be established, North Island was not included in air emissions testing.

Air emissions testing included source emissions sampling of the ductwork (using USEPA Method 306) exiting from the hard chromium electroplating baths (i.e., prior to existing APCDs), and also occupational area sampling (using OSHA Method 215). Air emission samples were taken during days of testing at NAPED Cherry Point (3 days without WA/FS, and 5 days with WA/FS in the bath), and during 6 days of testing at Tinker AFB (1 day without WA/FS, and 5 days with WA/FS). During the testing routine full-load electroplating operations were conducted.

Hard chromium product quality performance tests, per Aerospace Material Specification (AMS) QQ-C-320, include hardness, hydrogen embrittlement, thickness, adhesion and porosity. Samples were taken before and after the addition of Fumetrol® 140 at NAPED Cherry Point and Tinker AFB. Since North Island already uses the WA/FS, the project evaluates samples generated at North Island only while using WA/FS. Fatigue evaluation was achieved by following a Limited Equivalence Fatigue test plan developed by Naval Air Systems Command (NAVAIR). For the fatigue tests, specimens were plated at NAPED Cherry Point from tanks with and without WA/FS.

1.3 Regulatory Issues

Numerous air quality regulations at the local, state, and federal levels affect the hard chromium electroplating industry. Also, OSHA regulates occupational exposure to hexavalent chromium.

In 1995, USEPA promulgated its *National Emission Standards for Hazardous Air Pollutants (NESHAP) for Chromium Emissions from Hard and Decorative Chromium Electroplating and Chromium Anodizing Tanks* Code of Federal Regulations (CFR), Part 63, Subpart N (Ref. 1)). Under these standards, facilities that perform chromium plating must demonstrate that chromium emissions do not exceed acceptable limits, and must also satisfy monitoring, record keeping, and reporting requirements. Table 1-1 is a synopsis of the current hexavalent chromium electroplating standard. It can be seen from Table 1-1 that *decorative* chromium electroplaters do not have to meet a quantitative emissions standard if they achieve a specific bath surface tension by the application of WA/FS. USEPA's Office of Air Quality Planning and Standards (OAQPS) is considering allowing the use of WA/FS additives for hard chromium electroplating as well, based on work done under the Common Sense Initiative (a joint USEPA and American Electroplaters and Surface Finishers program), and studies such as this one. However, no such regulation is currently planned or proposed in the immediate future for Hard Chromium Electroplating Emissions.

OSHA currently regulates hexavalent chromium under Title 29 CFR 1910.1000, Table Z-2, Limits for Air Contaminants. The current PEL is a ceiling value of 100 micrograms/cubic meter ($\mu\text{g}/\text{m}^3$) as chromic trioxide (CrO_3), which equates to $52 \mu\text{g}/\text{m}^3$ as chromium. ($100 \mu\text{g}/\text{m}^3$ is equivalent to 0.1 milligrams/cubic meter [mg/m^3]). However, OSHA was petitioned for an emergency temporary standard in July 1993 and is expected to issue a new hexavalent chromium standard shortly. A recent court case set dates for the proposed regulation and the final regulation at 04 October 2004 and 18 January 2006 respectively. The anticipated standard is expected to be between 5.0 and $0.5 \mu\text{g}/\text{m}^3$ as chromium. This is about a 10- to 100-fold reduction below the current regulatory level. Naval Sea Systems Command (NAVSEA) heavy metals studies, primarily in welding and cutting operations, show that the Navy and the commercial ship building industry, in most cases, will be able to meet the $5.0 \mu\text{g}/\text{m}^3$ value but not the $0.5 \mu\text{g}/\text{m}^3$ value. Results of the current project suggest that this might also be the case for hard chromium electroplating bath occupational exposures when WA/FS is not used. However, when WA/FS is used, it is quite likely that DOD hard chromium operations will easily be able to meet the more stringent $0.5 \mu\text{g}/\text{m}^3$ standard.

Table 1 – 1. USEPA Standards for Chromium Plating and Anodizing Baths

| Type of Bath | Emission Limitations | |
|--|---|---|
| | Small Facility (<60 million amp-hrs/yr) | Large Facility |
| <i>Hard Chromium Plating Baths</i> | | |
| All existing baths | 0.03 milligrams/dry standard cubic meter (mg/dscm) (1.3 x 10 ⁻⁵ grains/dry standard cubic foot [gr/dscf]) | 0.015 mg/dscm (6.6 x 10 ⁻⁶ gr/dscf) |
| All new baths | 0.015 mg/dscm (6.6 x 10 ⁻⁶ gr/dscf) | 0.015 mg/dscm (6.6 x 10 ⁻⁶ gr/dscf) |
| <i>Decorative Chromium Plating Baths Using Chromic Acid</i> | | |
| All new and existing baths | 0.01 mg/dscm (4.4 x 10 ⁻⁶ gr/dscf) or Surface Tension of <45 dynes/centimeter (3.1 x 10 ⁻³ pounds/foot [lbf/ft]) | |
| <i>Chromium Anodizing Baths</i> | | |
| All new and existing baths | 0.01 mg/dscm (4.4 x 10 ⁻⁶ gr/dscf) or Surface Tension of <45 dynes/centimeter (3.1 x 10 ⁻³ lbf/ft) | |

The only other regulatory issue stems from a new USEPA rule (67 FR 11007, 11 March 2002, Perfluoroalkyl Sulfonates (PFOS); Significant New Use Rule that could affect the use of the WA/FS tested for this project (Fumetrol® 140)). The rule requires that manufacturers of perfluorooctyl sulfonate compounds notify USEPA before commencing manufacture or importing of these substances. USEPA is concerned that these compounds, which appear to be the primary active ingredient in Fumetrol® 140, may be “hazardous to human health and the environment.” This rule has no immediate effect on the use of WA/FS. However, it is conceivable the rule might lead to banning or reducing the use of such compounds for certain uses. The recommended dosage of Fumetrol® 140 for hard chromium electroplating baths is only 0.25 percent. It is unlikely that such low concentration use would ever be regulated for hard chromium operations, especially since its function is to reduce significantly the environmental and occupational exposure to a known carcinogen (i.e., hexavalent chromium).

1.4 Previous Testing of the Technology

USEPA’s National Risk Management Research Laboratory (NRMRL), tested Fumetrol® 140 WA/FS at Hohman Plating and Manufacturing Incorporated, Dayton, Ohio and several other facilities. Hohman falls under the category of a “large facility” for USEPA reporting and control technology purposes. (DOD operations fall in the same category.) Several papers, including *Use of Fume Suppressants in Hard Chromium Baths - Quality Testing* and *Use of Fume*

Suppressants in Hard Chromium Baths-Emission Testing (Refs. 2 and 3), developed for technical and end-user publications describe the test results.

During USEPA's testing, using OSHA and National Institute of Safety and Health (NIOSH) sampling procedures, it was shown that the concentration of hexavalent chromium in the airspace directly above the electroplating bath decreased three orders of magnitude with the addition of WA/FS. During normal operating conditions, using WA/FS, workers at the tested facility were exposed to hexavalent chromium below the current PEL of 52 $\mu\text{g}/\text{m}^3$ as chromium, but above the most stringent proposed PEL of 0.5 $\mu\text{g}/\text{m}^3$ as chromium. No conclusions could be drawn confirming that Fumetrol® 140 will provide compliance with the anticipated OSHA standards.

Material quality testing showed that the Fumetrol® 140 had no negative effects on plating quality. In fact, adding Fumetrol® 140 tends to increase microhardness. While, some negative outcomes (e.g., pitting tests) were observed during testing, the same negative outcomes were observed from samples taken from baths not containing WA/FS. Inferior quality outcomes were attributed to poor preparation before plating.

2. Technology Description

2.1 Description

2.1.1 Theory

WA/FS are defined as any chemical, added to the electroplating bath, that reduces or suppresses fumes or mists at the surface of the bath (40 CFR 63). Electroplating baths, and in particular hexavalent chromium baths, emit bubbles of hydrogen and oxygen at the bath cathode and anode respectively. In fact, for hexavalent chromium electroplating baths, 85 to 90 percent of the electrical energy supplied to the baths produces bubbling. (The other 10 to 15 percent causes chromium to plate on the substrate metal.) These bubbles (and also the bubbles produced by mechanical aeration of the baths) burst as they rise to the surface of the baths, causing the production of chromic acid mist.

“Surface active” fume suppressants (also called surfactants) are added directly to chromium plating baths and are classified as either temporary or permanent. Fume suppressants are further divided into the way they reduce emissions. Foam “blankets” typically suppress the mists produced on the surface of plating baths, while wetting agents change the surface chemistry (i.e., the surface tension) of the plating baths to reduce misting.

WA/FS reduces the surface tension of a liquid. When WA/FS lower the surface tension of a plating bath, gases escape at the surface of the solution with a diminished “bursting” effect, causing less mist formation (i.e., smaller bubble size, less surface impact). WA/FS chemicals are organic compounds whose components have opposing solubility tendencies, typically an oil-soluble hydrocarbon group and a water-soluble ionic group. The “third generation” WA/FS product tested in this demonstration is Fumetrol® 140, a liquid distributed by Atotech USA, Inc., Rock Hill, South Carolina.

The “first generation” WA/FS were hydrocarbon-based with an ionic group at one end, such as kerosene or paraffin oils. The disadvantages of the first generation surfactant outweighed the benefits. The oil components were layered on the surface and carried over to the rinse tanks. Health and safety issues included possible fire hazards and dermatitis. Further, these WA/FS oxidized rapidly producing trivalent chromium and insoluble organic compounds that eventually decomposed to carbon dioxide. This behavior required frequent or continuous WA/FS additions, making them a more temporary than permanent solution. The trivalent chromium was also a bath contaminant requiring the plating bath to be replaced/regenerated more often.

In the “second generation” WA/FS, the hydrocarbon chain was replaced with a fluorinated or perfluorinated carbon chain. This WA/FS, which was first reported in the chromium plating industry in 1954, can be considered permanent since it has been found to remain stable in boiling concentrated chromic acid, and is tolerant to the highest oxidizing conditions existing at the electroplating bath anodes. The original second generation WA/FS, although chemically neutral, was a cationic surfactant with a dihydroamine functional group. The amine group was later replaced with the sulfite group that changed the surfactant to anionic. The active ingredients in

the second generation WA/FS include potassium perfluoroalkyl sulfonate, amine perfluoroalkyl sulfonate, potassium perfluoroethyl cyclohexyl sulfonate, and ammonium perfluorohexylethyl sulfonate. These WA/FS have a low solubility and become suspended causing roughness, porosity, and cracking on the chromium plate during hard chromium plating operations. Salt was added to these WA/FS compounds to improve solubility. The salt itself may have caused adverse effects on product quality.*

The “third generation” WA/FS (introduced in the late 1980s/early 1990s) being tested in this study are also perfluorinated but with higher solubility and lower foaming. Supplemental chemical additives are not required to improve the solubility. Active ingredients include organic fluorosulfonate and tetraethylammonium-perfluorocetyl sulfonate. Another benefit of the third generation WA/FS is that there appears to be no adverse effect on the chromium plate, basis metal, or process equipment during hard chromium plating operations.

2.1.2 Process Description

This project demonstrates that the third generation WA/FS additive to hard chromium electroplating baths reduces hexavalent chromium airborne emissions to the environment and employee occupational exposures in the electroplating shop. Further, emissions of hexavalent chromium are expected to be low enough that regulatory agencies may not require the use of APCDs on exhausts from hard chromium electroplating operations. (Currently, USEPA does not require APCDs for *decorative* chromium electroplating operations that use the appropriate amount of WA/FS.)

2.1.2.1 *Installation and Operational Requirements*

The process of using WA/FS to control emissions of hexavalent chromium from hard chromium electroplating baths is quite simple. It consists of adding approximately 0.25 percent by volume of the Fumetrol® 140 liquid WA/FS to a hard chromium electroplating bath (i.e., 2-½ gallons of WA/FS to a 1,000-gallon bath), and allowing a short period of time (hours) for the bath contents to reach equilibrium. This procedure effectively lowers the surface tension of the bath from above 70 dynes/cm (as measured by a De Nouy Ring Tensiometer) to below 30 dynes/cm. Additional Fumetrol® 140 is added over time as required to maintain the surface tension below 30 dynes/cm. These additions are relatively small, because the WA/FS is stable in the plating bath. Replacement is essentially for mists carried out the exhaust stack, dragout, and splashing.

* Private e-mail from David Ferguson, USEPA, Fume Suppressants Summary, 3/22/99

2.1.2.2 Design Criteria

There is no capital equipment involved with the application of WA/FS. The only criterion is that the surface tension of the bath be monitored and maintained. Monitoring requires the purchase of a De Nouy Ring Tensiometer (another less expensive surface tension measuring device is a stalagmometer). The tensiometer was chosen to ensure a more accurate reading and to eliminate operational differences between test sites. The surface tension should be measured according to the regimen discussed in the decorative chromium standard shown in Table 2-1. If surface tension measurements indicate that more WA/FS is required, it should be added to bring the bath to the desired value (i.e., below 30 dynes/cm). Personal correspondence at the time this study was being developed indicated that EPA plans to require different surface tension values depending on the test equipment. The stalagmometer target surface tension value would remain at 45 dynes/cm and the target value using a tensiometer will be 30 dynes/cm. Since the tensiometer was used in this project, the bath surface tension was targeted to be below 30 dynes/cm. In addition, it was desired to test occupational/environmental health and safety and material quality characteristics at the lowest practical surface tension to identify potential effects on in-house air quality and on material quality of tactical equipment.

Table 2-1. Surface Tension Monitoring Protocol

| Trigger | Monitoring Frequency | Test Period | Passing Criterion |
|-------------------------------|-----------------------------|--------------------|-----------------------------------|
| New tank solution | Every 4 hrs | 40 hours | No exceedances |
| Pass 40 hours | Every 8 hrs | 40 hours | No exceedances |
| Pass 80 hours | Every 40 hours | Indefinite | No exceedances or solution change |
| Exceedance or Solution change | Start all over | | |

As seen in Figure 2-1, the hard chromium electroplating bath (or more than one bath) is vented to an air scrubber. Water is recycled through the scrubber to remove the chromic acid mist from the air stream. A portion of the recycled water is blown down to a wastewater treatment facility, where the chromium is ultimately removed from the wastewater as hazardous waste sludge. Note that the test point was always located between the hexavalent chromium-containing tank and before the scrubber.

2.1.2.3 Process Schematic and Description

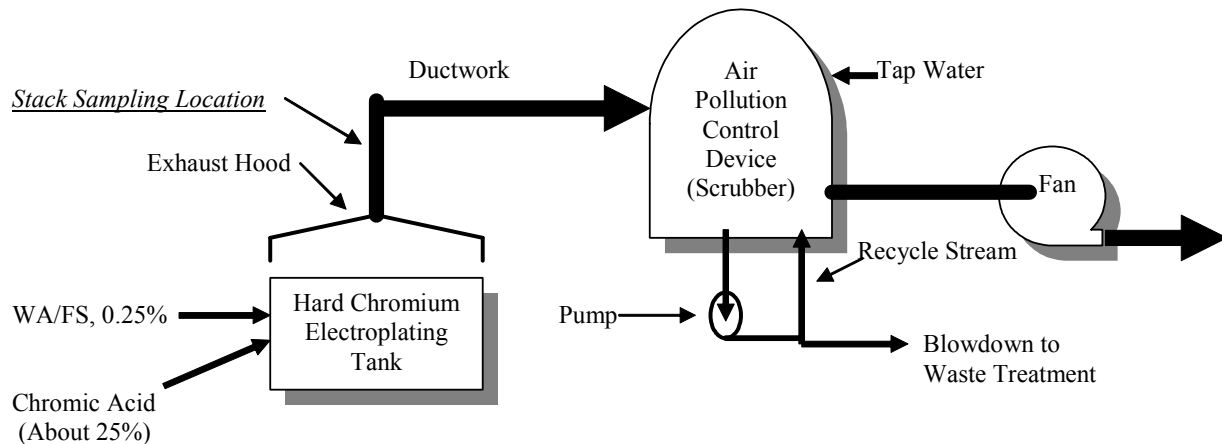


Figure 2-1. Process Schematic.

2.2 Strengths and Weaknesses

2.2.1 Strengths

The advantages are that the WA/FS technology is very simple and inexpensive. Initial cost estimates are around \$800 per year per 1,000-gallon bath (including the initial WA/FS addition). Cost savings are expected to occur from reduced maintenance of existing air pollution control devices (APCDs), less wear and tear on the ventilation hoods, ductwork, and exhaust fans, savings in chromic acid because less chromic acid mist escapes the bath, savings in water used in APCDs (i.e., air scrubbers), and savings in the cost of treating the wastewater from APCDs. Ultimately, DOD could obtain significant savings if air pollution equipment were no longer required on future plating lines.

DOD is investigating methods of replacing hard chromium electroplating with other more environmentally friendly coating methods. Other technologies are constantly being evaluated for the purposes of minimizing or eliminating the need for hexavalent chromium-based electroplating, or minimizing emissions from such plating. Thus far none of these technologies have been successfully implemented in applications that are currently served by conventional hard chromium electroplating. Some examples are:

- **Tank Lids/Covers:** Covering hard chromium electroplating tanks during plating operations reduces the amount of ventilation required, thus reducing the amount of contaminated air that is exhausted from the plating operation. However, this approach is not popular because it enhances the possibility of explosive situations (i.e., hydrogen buildup), and interferes with the ability to operate the plating baths on an uninterrupted basis (i.e., electroplating must cease every time the cover is removed to add a part to the bath).

- High Velocity Oxy-Fuel (HVOF) Thermal Spray Systems: This is a technology that allows the application of chromium to metal substrates through high temperature techniques. However, the application is limited to line-of-sight coatings, whereas electroplating provides for more uniform coatings. Consequently, HVOF may somewhat reduce the need for hard chromium electroplating, but is not expected to ever be able to eliminate it.
- Trivalent Chromium Electroplating: Chromium can be electroplated from a trivalent chromium bath (e.g., chromium sulfate). Trivalent chromium is much less toxic than hexavalent chromium. However, thus far, trivalent chromium techniques do not yield the quality of coating, or the rate of deposition that is available from hexavalent plating.
- Alternative Coatings: On an research and development (R&D) basis, several nickel and cobalt alloys have been evaluated as alternatives to chromium coatings. Much study is still required to determine if the coating quality is as good as chromium when subject to real-world conditions.

However, NADEP Cherry Point estimates that after much of the high technology processes currently undergoing research are implemented, approximately 20 to 40 percent of their existing hard chromium electroplating operations will continue. This estimate is reasonable for all other DOD hard chromium plating facilities as well. Many of the high technology processes cannot plate in non-line-of-site areas such as recesses and pinch points. Therefore, even if alternative and/or high tech alternative technologies are implemented, the activity will still have a need for conventional chromium electroplating baths in the foreseeable future.

2.2.2 Weaknesses

Preliminary tests performed by the USEPA's NRMRL show that there are no limitations to plated product quality while using the WA/FS additive.

However, there are anecdotal stories that WA/FS is not appropriate for hard chromium plating on cast iron since the cast iron already has significant pitting. However, USEPA tested one cast iron sample and found no effect on material quality. Otherwise there are no restrictions on types of substrate to be plated.

USEPA recently discussed the project with Delta Faucet Company, which uses WA/FS for decorative chromium plating. Delta found that cathode efficiency decreases when using fume suppressants. This is the only other negative item reported when using the newest suppressants (i.e., third generation WA/FS). The efficiency loss may slightly change the power requirements for the plating process. However, this phenomenon could not be evaluated during this study.

2.3 Factors Influencing Cost and Performance

2.3.1 Factors Influencing Cost

There are two general factors that influence the economics involved in using WA/FS to reduce emissions of hexavalent chromium from hard chromium electroplating baths: (1) the cost of implementing the WA/FS addition, and (2) the cost savings realized by the use of WA/FS. Detailed cost analysis is given in Section 6.0.

The only direct costs required for implementation of the technology are the cost of purchasing the WA/FS, Fumetrol® 140, and the relatively low cost of monitoring its concentration to ensure that proper emissions performance is maintained. These activities are described in section 2.2.

More specifically, startup costs are approximately \$800 per bath, including an initial WA/FS charge costing about \$300 to make up the bath initially (800 gallon bath with 2 gallons of WA/FS). Shop personnel require approximately 2 hours to familiarize themselves with the material safety data sheets and the material addition practices. The material is in liquid form and is added to the bath via mixing. Mixing ingredients into baths is not a new procedure for shop personnel.

As part of the startup costs each site must purchase and use a tensiometer at a cost of approximately \$2,500 to perform accurate surface tension measurements. During the life of the tensiometer (well over 10 years), it is expected that the tensiometer platinum wire test ring will be replaced at a cost of \$260 every 2 years. Laboratory personnel will require approximately 4 to 6 hours to familiarize themselves with the tensiometer test method. Further, there will be an additional cost for the laboratory personnel to take periodic tensiometer measurements.

There may also be a small amount of documentation and computer-related cost to identify those parts electroplated using a WA/FS amended bath, as well as documentation to track the addition of the WA/FS. It is also likely that some time will have to be spent incorporating the use of WA/FS into hard chromium electroplating specifications, both at the shop level, and at other levels within DOD.

Initially, there are indirect costs related to the use of WA/FS. One of those costs is related to monitoring the quality of the parts electroplated in a WA/FS bath (relative to those that are not).

Other potential indirect cost savings will be based on a determination by individual shops as to whether existing APCDs can be “turned off” (i.e., turning off water feed to scrubbers, and not having to treat scrubber blowdown) because compliance with atmospheric emission regulations is achieved by using WA/FS alone. For new shops, the purchase of APCDs (i.e., scrubbers) may not be required, saving at least \$200,000 in capital cost per shop (based on the cost of the NADEP Cherry Point hard chromium bath scrubber system). It is also expected that between \$800 and \$3,200 per bath, per year will be saved in chromic acid costs, because the WA/FS will ensure that acid that had escaped the bath as mist, through the ventilation system, will remain in

the baths. Ventilation system ductwork and fans as well as other plating shop equipment may last longer because there is less chromic acid to corrode and decompose them.

There are also likely to be occupational health benefits to plating shop workers because concentrations of chromium will be reduced from their pre-WA/FS levels. The cost avoidance of reducing hexavalent chromium exposure cannot be quantified since cancer manifests itself only after a long latency period.

2.3.2 Factors Influencing Performance

The only significant factor influencing the performance of the WA/FS appears to be its concentration and surface tension. Concentration of WA/FS is proportionate to the depression of the surface tension. Even though the target surface tension for this study was 30 dynes/cm or less, performance equivalent to 30 dynes/cm was achieved at surface tensions as high as 34 dynes/cm (which was the highest surface tension value occurring during the tests in which WA/FS was present) (see Section 5.1.1)).

It is likely that bath temperature will also influence emissions, because surface tension usually decreases as temperature increases. However, the temperature parameter becomes somewhat academic, since all hard chromium electroplating baths are usually kept in the same temperature range (typically about 120 to 150°F).

The design of the bath ventilation system probably influences the amount of mist that is entrained in the exhaust gasses versus the amount that falls back into the bath or escapes into the shop. Regardless, during testing at NADEP Cherry Point and Tinker AFB, even though the baseline (i.e., without WA/FS) emissions were significantly different between the two facilities, the controlled emissions (i.e., with WA/FS) from both facilities were extremely low (see Section 5.1.2).

With respect to electroplated product quality, it can best be said that there is probably no statistical difference in product quality whether or not WA/FS is in use (see Section 5.1.4).

3.0 Site/Facility Description

3.1 Background

After obtaining a list of Army, Air Force, and Navy bases that perform electroplating, contact was made with the plating engineering departments operating at all three service branches.

Telephone conversations with the various electroplating facilities engineers indicated that NADEP North Island, San Diego, California, has satisfactorily used Fumetrol® 140 to reduce emissions since 1998. However, their target surface tension level is unclear. Reports range from 25 to 40 dynes/cm. Further, NAVAIR has not tested the Fumetrol® 140 for material integrity. Nor has NAVAIR approved the use of the Fumetrol® 140.

NADEP North Island made their decision to use Fumetrol® 140 after experiencing a temporary shut down for shop repairs approximately 5 years ago. They transferred their workload to an electroplating job shop that used Fumetrol® 140. The Federal Aviation Authority (FAA) had approved the job shop to electroplate new and reworked parts for several DOD prime contractors. Based on that FAA approval, NADEP North Island's shop and engineering management made a decision to use the additive. After a Temporary Engineering Investigation, North Island incorporated the product into their Local Process Specifications.

At the time of site selection, NADEP North Island was in the process of redesigning their electroplating shop, including the hard chromium lines. They were also still in the process of obtaining a renewed air emissions permit. Therefore, it was decided to forego air emissions testing (stack and occupational exposure) at NADEP North Island. However, their materials quality testing data is being evaluated.

NADEP Cherry Point, Havelock, North Carolina, was also interested in implementing WA/FS use if NAVAIR approves of the use in hard chromium baths. NADEP Cherry Point was chosen to serve as NAVAIR's test site for this study.

Hill AFB evaluated Fumetrol® 101, a second generation WA/FS, with unsatisfactory results and at the time of site selection, were disinclined to try the new generation Fumetrol® 140. However, later discussion (after validation began) with other Hill AFB staff indicates that they are extremely interested in this generation of WA/FS and await ESTCP test results.

Tinker AFB typically electroplates engine parts that are not subject to the same stresses and mechanical performance requirements as structurally critical parts such as landing gears. They were willing to participate in this study and served as the Air Force test site.

Participation was solicited at several Army posts. However, they appear to be satisfied with their progress in reducing hexavalent chromium emissions using their current technologies. Watervliet Arsenal's gun barrel plating operation is an entirely closed loop system (i.e., it has no wastewater discharge). Their APCD has a 95 percent efficient first stage and polishers in the three remaining stages. They passed a Maximum Achievable Control Technology (MACT) test

at 95 percent rectifier capacity and did not need additional emission reduction. Phone calls to other Army installations proved equally unsuccessful.

To keep the project manageable, emissions' testing was limited to one Navy and one Air Force shop that had expressed interest in participating (i.e., NADEP Cherry Point and Tinker AFB). Electroplating for the material quality testing took place at both facilities, and also at North Island. Work at all three shops is typical of the rework operations performed at DOD facilities, in contrast to production operations performed in a prime contractor's shop. Part configurations change from day to day in a rework shop while a production shop tends to plate the same type of part day after day.

Since selecting the three DOD sites, interest has been expressed by Boeing, Saint Louis, Missouri, who has been involved with using Fumetrol® 140 for chromic acid anodizing (in fact Boeing led the way for this to happen and validated its use for MIL-A-8625). Boeing is very interested in seeing how Fumetrol® 140 works with hard chromium plating. NAVAIR approval of the WA/FS will lead the way for Boeing to use it for original equipment manufacturer (OEM) parts on important NAVAIR platforms like the F/A-18E/F.

3.2 Site/Facility Characteristics

Within DOD, there are at least nine major facilities that have hard chromium electroplating operations:

- NAVAIR – NADEP Cherry Point, North Island, and Jacksonville
- Air Force – Tinker AFB, Ogden, and Hill
- Army – Corpus Christi, Watervliet, and Anniston

The NAVAIR facilities have three to eight hard chromium electroplating baths each. If it is assumed that each of the above facilities has 6 baths, then there are at least 54 baths within DOD that would be amenable to the WA/FS technology. In addition, there are a multitude of such facilities in the private sector.

The hard chromium electroplating facilities and baths included in this project for emissions testing purposes are:

- Naval Aviation Depot, NADEP Cherry Point, North Carolina - Tank No. 155
- Air Logistics Center, Tinker AFB Air Force Base, Oklahoma City, Oklahoma - Tank No. 222

3.2.1. Naval Aviation Depot, NADEP Cherry Point

The NADEP Cherry Point electroplating shop contains 50 tanks. Of these tanks, 5 are chromium electroplating baths. All 5 tanks are active, and contain between 422 and 810 gallons capacity. They exhaust into one MAPCO four-stage polymer mesh pad scrubber, rated at 40,000 cubic feet per minute (cfm). Tank No. 155, the emissions of which are being tested in this study, is an 800-gallon bath with about 8 inches of freeboard, and a surface area of about 21.5 square feet. About

3.2 square feet of lip vent along one long side of the bath provides ventilation. See Appendix C for photographs of Tank No. 155, and the fume scrubber for emissions from hard chromium electroplating operations.

There are, in total, approximately 100 tanks in the electroplating shop. NADEP Cherry Point has the capability for Type I, II, and III anodizing; and nickel, silver, cadmium, and tin plating. They have recently implemented tin-zinc and zinc-nickel plating and chemical-milling capacity. They plate landing gear and aircraft components for the AV-8B, H-53, H-46, C-130, C-2, and P-3 aircraft. Currently they are implementing a HVOF system as a line-of-sight chromium replacement.

3.2.2 Air Logistics Center, Oklahoma City (Tinker AFB)

The shop at Tinker AFB contains 202 process tanks not including the masking and demasking tanks. There are six active hard chromium baths; all have a 1,466-gallon capacity. Tank No. 222, the emissions of which are being tested in this study, has about 7-½ inches of freeboard, and about 26.8 square feet of surface area. About 2.7 square feet of lip vents along both long sides of the bath provides exhaust ventilation. See Appendix C for photographs of Tank No. 222. In addition to the hard chromium tanks there is one chromium etch tank and five chromium rinse tanks. There are also three process tanks designated for chromate conversion.

There are 35 baths on the chromium plating line alone. The chromium line exhausts to one of two scrubbers, one for chromium emissions, and the other for acid and alkaline processes (e.g., acid etch, chromium strip, alkaline cleaning, electrocleaning, etc.) in the shop. The Tinker AFB facility was rebuilt in the early 1990s and is a well-planned facility.

3.2.3 Naval Aviation Depot, North Island

NADEP North Island's electroplating line consists of 77 process tanks. There are two chrome rinse tanks and an acid etch activation tank. Although not available for testing, NADEP North Island has six chromium electroplating baths, five of which are active. They exhaust into one MAPCO five-stage composite mesh pad scrubber. The MAPCO system consists of four composite-mesh pads (Stages I, III, IV, and V) with chevron-type blades in Stage II. Due to renovations at NADEP North Island, air emissions sampling could not be scheduled around their compliance sampling requirements. See Appendix C, Figure C-9 for a photograph of NADEP North Island scrubber system (which is similar in function to the scrubbers at Tinker AFB and NADEP Cherry Point).

4. Demonstration Approach

4.1 Performance Objectives

The primary project objective was to provide data to the regulatory arm of the USEPA supporting the inclusion of WA/FS as a MACT for hard chromium electroplating. Such an alternative is currently available to decorative chromium operations. The project was designed to demonstrate that a WA/FS reduces atmospheric emissions during routine electroplating operations. The intent was to show that if the WA/FS keeps the surface tension at or below about 30 dynes/cm, atmospheric emissions (i.e., stack emissions) from a hard chromium electroplating bath would remain below the most stringent hexavalent chromium regulatory limit of 15 $\mu\text{g}/\text{dscm}$ (see Section 1.3). Consequently, WA/FS additives are proposed as an effective alternative to mechanical APCDs such as mesh pad mist eliminators.

A second objective was to demonstrate that there is a significant reduction in fugitive emissions from the bath. Fugitive emissions increase the occupational health exposures of the workers in the shop. WA/FS additives are reported to reduce occupational exposures below the current PEL of 52 $\mu\text{g}/\text{m}^3$ as chromium, but may not be able to reduce the exposure below the most stringent anticipated PEL of 0.5 $\mu\text{g}/\text{m}^3$ (see Section 1.3). The intent was to show that there is a significant drop in fugitive emissions that leads to lower occupational exposures. However, the demonstration project configuration prevented performance of personnel sampling on the individual workers. Stationary air samples were taken instead. Stationary samples probably overestimate exposure, because they remain near or at the source of emission for the entire monitoring time. In addition, actual workers do not spend all their time at the source.

The third objective was to certify that WA/FS does not negatively affect the integrity of the electroplating process, the hard chromium coating, or the functional properties of the plated components. Critical properties are fatigue characteristics and embrittlement. Hard chromium is plated on platform-critical components at DOD facilities. Successful evaluation requires that materials electroplated in hard chromium baths treated with WA/FS perform as well as materials treated in baths without WA/FS.

4.2 Physical Setup and Operation

Figures C-1 through C-8 of Appendix C show the hard chromium electroplating baths and emissions sampling equipment used at NADEP Cherry Point and Tinker AFB. At NADEP Cherry Point, the exhaust ductwork for the bath sampled (Tank No. 155) is routed through the basement, beneath the shop floor. The duct sampled is a 20-inch diameter fiberglass reinforced duct that runs horizontally through the basement. Two 2-½ inch sample ports were drilled in the duct for sampling purposes, 90 degrees apart on the duct cross-section. The sampling ports were about 8 feet from the nearest upstream restriction (a 90-degree bend in the ductwork), and about 4 feet from the nearest downstream restriction (another bend in the ductwork). At Tinker AFB, the 22-inch fiberglass ductwork from the bath sampled (Tank No. 222) runs vertically up toward the ceiling. The two sampling ports were also located 90-degrees apart from one another, about 6-½ feet above the nearest upstream restriction (the converging section of the exhausts on both

long sides of the bath), and over 7 feet from the nearest downstream restriction (a 90-degree bend).

Industrial hygiene (IH) sampling (i.e., ambient shop air sampling) was performed at both NADEP Cherry Point and Tinker AFB. Some of the samplers used are shown in Figure C-6, Appendix C. Samples were typically taken: (1) a few inches above the surface of the baths in two locations for each bath, (2) at the breathing zone directly in front of the baths, also in two locations, and (3) at the breathing zone a few feet in either direction from the baths. At each of the sampling locations, one or two samples were taken during each sampling day. If one sample was taken, it was taken continuously for about 8 hours. When two samples were taken at a location, each sample was taken for approximately 4 hours.

Eight days of sampling were conducted at NADEP Cherry Point. The first, second, and fourth days (11 July, 12 July, and 15 Nov 00) were sampled with no WA/FS in the bath. During the other 5 days (21 Sep, 16 Nov, 13 Dec 00, 27 Mar, and 17 Apr 01), WA/FS was present in the bath at the following respective surface tensions (in dynes/cm): 33, 23, 23, 27, and 27. For the first sampling day (11 July 00) there was a polyethylene shield placed around the front and sides of the bath, about four feet high (a permanent metal plate formed the fourth side). The purpose of the shield was to segregate Tank No. 155 from the rest of the shop environment. However, it was later agreed that the shield presented an unrealistic situation, and was deleted from subsequent sampling events.

Six days of sampling were conducted at Tinker AFB. The first day (12 Sep 00) there was no WA/FS in the bath. During the other 5 days (11 Oct, 08 Nov, 06 Dec 00, 31 Jul 01, and 01 Aug 01) WA/FS was present in the bath at the following respective surface tensions (in dynes/cm): 34, 27, 30, 28, and 28. In order to get a second day of IH sampling at Tinker AFB while no WA/FS was in the bath (i.e., another baseline set of IH samples), a set of IH samples was taken on the 01 Aug 01 sampling date in and around Tank No. 214 instead of Tank No. 222. (Tank No. 222, which contained WA/FS, was sampled on 01 Aug for atmospheric emissions only (i.e., stack emissions.) Tank No. 214 is identical in size and operation to Tank No. 222, but did not contain WA/FS.

During all sampling events, chromium electroplating of actual production parts or of “dummy” parts was continuously conducted. Dummy parts were used to increase the load on the tank when actual production parts were unavailable.

4.3 Sampling Procedures

In general, sampling procedures were conducted in accordance with Appendix D, Table D-1, and in conformity with the *Quality Assurance Plan in the Technology Demonstration Plan, 15 October 2000, Appendix E* (Ref. 4).

Air pollution emissions tests (i.e., stack tests in the ductwork between baths and the APCDs) were conducted using USEPA Method 306, *Determination of Chromium Emissions from Decorative and Hard Chromium Electroplating and Anodizing Operations* (Ref. 5) (60 FR 4963, 25 January 1995) sampling trains (basically a modified USEPA Method 5 train). Method 306 is

the conventional test for total and hexavalent chromium analysis for point source air emissions. The sampling equipment was leased and/or purchased from Clean Air Engineering (CAE), Palatine, Illinois. Calibration of appropriate portions of the sampling equipment was conducted by CAE prior to each testing event. Each emissions test was taken during a 2-hour period, using “isokinetic” sampling techniques mandated by Method 306. (Isokinetic means that the velocity of the gases being drawn into the tip of the stack sampling probe is exactly equal to the velocity of the gases in the exhaust system ductwork.) Three 2-hour emissions tests were conducted during each sampling day.

Briefly, in the Method 306 sampling train, exhaust emissions are removed from the stack using a glass nozzle (a 3/16-inch diameter nozzle was used for all testing except: for the first run on 11 Jul 00 at NADEP Cherry Point a ¼-inch nozzle was used; for the third run on 31 Jul 01 at Tinker AFB a 1/8-inch nozzle was used; for all three runs on 01 Aug 01 at Tinker AFB a ¼-inch nozzle was used). During each 2-hour test the sampling nozzle was repositioned every 7½ minutes to another sampling location (as prescribed in Method 306), for a total of 16 sampling positions. Gases passing through the nozzle entered a glass probe liner (about 3 feet long), and then entered a glass collection system consisting of four impingers in series. The first and second impingers that the gases entered each contained 100 milliliters (ml) of 0.1 “normal” (N) sodium hydroxide (about 0.4 percent sodium hydroxide). The purpose of these impingers is to absorb any chromic acid mist. The third impinger was empty (to catch any liquid carry-over), and the fourth impinger contained a weighed amount of silica gel (about 200 grams) to remove all traces of moisture from the gas stream. During sampling, all four impingers are placed in a container filled with ice to condense moisture. The gases exiting the fourth impinger are routed to a metering box through a rubber umbilical cord. The metering box contains the appropriate hardware to: measure the gas flow through the sampling train; measure the velocity pressure in the stack (which is related to the stack gas velocity); control the gas flow rate through the sampling train (to maintain isokinetic conditions); and, measure the temperatures at various locations in the sampling train. To determine the amount of chromium (hexavalent or total) in the sampled air stream, the liquid from the first three impingers is mixed with liquid obtained from rinsing all the sampling train glassware. (Triple rinsing was done on the glass probe nozzle, glass probe liner, and the Teflon® umbilical cord connecting the liner to the first impinger. Double rinsing was done on all other glassware.) The resulting mixture is analyzed for chromium concentration. That concentration, along with the total volume of liquid (impinger contents and rinse water) are used to determine the total chromium mass captured during the sampling event. The value for mass is combined with the volume of air sampled to derive the concentration of chromium in the air stream. As noted earlier, three samples, one from each 2-hour test, were sent to the analytical laboratory for each sampling day. (The laboratory used was Research Triangle Institute, Research Triangle Park, North Carolina.) In addition, one field blank was included for each sampling event. (The blank was a sample containing only 0.1 N sodium hydroxide solution.)

As appropriate, the results for each sampling day were obtained by averaging the data from each of the three tests taken that day. The testing schedule is shown in Appendix D, Table D-3.

IH area sampling was conducted using OSHA Method 215 with the most recent modifications, *Hexavalent Chromium in Workplace Atmospheres* (Ref.6). In addition, all samples were

collected, shipped, and analyzed in accordance with Industrial Hygiene procedures outlined in the *Field Operations Manual* (Ref. 7). During each test day (see Appendix D, Table D-3 for test dates), samples were taken in three locations: a few inches above the surface of the baths, at the breathing zone directly in front of the baths, and at the breathing zone a few feet in either direction from the baths. As noted in Section 4.2, at each of the sampling locations one or two samples were taken during each sampling day. If one sample was taken, it was taken continuously for about 8 hours. When two samples were taken at a location, each sample was taken for approximately 4 hours. Samples were taken using Gillian Aircon 520AC pumps (Gillian is now owned by Sensidyne), operated at about 2.1 liters per minute.

Personnel monitoring was considered for evaluation of occupational exposures. However, as noted, area monitoring was conducted instead. Due to site limitations (one bath was monitored per shop), personnel sampling is not appropriate. Several publications warn that area sampling cannot be extrapolated to indicate personnel sampling results. However, *A Strategy for Assessing and Managing Occupational Exposure* (Ref. 8) states, “They [area samplers] can be used to measure emissions from process equipment or background levels of an environmental agent.” The reference then goes on to discuss the number of samples needed for personnel sampling but not area sampling. It suggests a minimum of six random samples in a similar exposure group. The same six sampling locations at each bath were sampled during each sampling day (except for 01 Aug 01 at Tinker AFB – see the last paragraph of Section 4.2). Since the locations of the samplers were essentially the same for each sampling event, more controlled conditions were realized than if personnel monitors were used.

The area samples are time-weighted averages. For chromium, there are no intermittent sample techniques, such as colorimetric indicator tubes. A previous Environmental Security Technology Certification Program (ESTCP) project evaluated a real-time monitoring device, based on spark induced breakdown spectrometry (SIBS) for hard chromium evaluation. SIBS technology is still in the development stage and using it would add significant costs to the study since it must be used by the manufacturer’s technical staff.

Appendix E contains samples of forms used in the field to record the test data for both stack emissions and IH sampling. Appendix E also contains step-by-step procedures for the stack sampling and chain-of-custody sample transmission forms.

Material quality testing was conducted for: (1) hydrogen embrittlement, (2) hardness, (3) porosity, (4) adhesion, (5) thickness, and (6) fatigue. Except for fatigue testing, all testing complied with Society of Automotive Engineers (SAE) AMS QQ-C-320, *Chromium Plating Electrodeposited* (Ref. 9). The standard test includes ASTM Methods listed in Appendix D, Table D-2. Limited equivalence fatigue testing is based on NAVAIR requirements and is detailed in Appendix F.

- Notched round bar specimens used for hydrogen embrittlement testing, were made from 4340 steel and purchased from Dirats Laboratories. One lot of hydrogen embrittlement coupons from each electroplating source is included in work at the Patuxent River Laboratory to assist in validating the rising step load technique.

- The Vickers Hardness test method was used to determine coating hardness. Samples from NADEP Cherry Point and Tinker AFB were run with and without WA/FS.
- Porosity tests were conducted on coupons from Tinker AFB and NADEP Cherry Point, both with and without WA/FS. Coupons were also tested from North Island, with WA/FS. (North Island does not hard chromium electroplate without WA/FS, so no coupons electroplated without WA/FS could be processed.)
- A bend-to-break adhesion test was used to evaluate the quality of adhesion of the chromium to the substrate. Five random samples of the original sets of 1-mil thick coatings from NADEP Cherry Point (with and without Fumetrol® 140), Tinker AFB (with and without Fumetrol® 140), and North Island (with Fumetrol® 140) were tested.
- Thickness is a criterion that measures how close to the requested thickness is from sample to sample, and also shows the uniformity of the coating. For each coupon and average of three measurements were taken.
- Fatigue specimens were designed by NAVAIR and Metcut per ASTM E 466 and ASTM E 606, manufactured by Metcut, and plated by NADEP Cherry Point. High-strength steel alloys 300M and Aermet 100 and corrosion-resistant high-strength steel alloy PH13-8 were used in the evaluation. They represent a good cross section of alloys for rotary and fixed wing components in the aerospace and defense community.

As noted in Section 4.2 and in Appendix D, Table D-3, a polyethylene barrier was erected on the first sample day at NADEP Cherry Point. Its purpose was to segregate the hard chromium bath emissions from other facility fumes, so that the samples taken just above the bath surface, and the samples taken at the breathing zone in front of the bath would not be effected by other shop fumes. However, it was concluded, after discussion with National Institute of Safety and Health (NIOSH) that the barrier is not necessary and may prevent observing the realistic effects of actual shop operations such as adjacent operations and cross drafts from open doors. Consequently, the barrier was never used beyond the first day, and only at NADEP Cherry Point.

After initial baseline testing without WA/FS (i.e., Fumetrol® 140) at both shops (i.e., NADEP Cherry Point and Tinker AFB), the WA/FS was added to the baths, attempting to reach a surface tension value of less than 30 dynes/cm. (See Appendix C, Figures C-7 and C-8 for visual difference between baths with and without WA/FS.) However, NADEP Cherry Point was only able to achieve a surface tension of 33 dynes/cm for the first day of testing with WA/FS (21 Sep 00) – see Section 9.1 for an explanation. Consequently, the bath contents at NADEP Cherry Point were removed, and replaced with fresh contents. Baseline tests were repeated with the new contents (i.e., without WA/FS) on 15 Nov 00, after which WA/FS was added, and all subsequent testing at NADEP Cherry Point was done with WA/FS. At Tinker AFB, baseline testing was done on 12 Sep 00. All subsequent testing was done with WA/FS. (See Appendix D, Table D-3 for the sampling schedule.)

4.4 Analytical Procedures

Research Triangle Institute (RTI), Research Triangle Park, North Carolina, analyzed the stack samples using USEPA Test Method 306 (which describes both the stack sampling and the sample analytical methodology).

IH samples (in-plant air samples collected on filters) were analyzed by the Naval Environmental Health Center, Consolidated Industrial Hygiene Laboratory (CIHL) at Navy Environmental & Preventative Medicine Unit No.2 (NEPMU 2), Norfolk, Virginia. NEPMU 2 holds an AIHA Accreditation (Laboratory No.102170, Certificate No.58, Accreditation expires Jan 01 03) for IH testing of metals. The in-plant air samples were analyzed according to OSHA 215. The analytical method is similar to the analytical method required by USEPA Method 306.

The Becker Laboratory at Patuxent River Maryland, NAVAIR's Aerospace Materials Division's main laboratory, and the Materials Engineering Laboratory, NADEP North Island, San Diego conducted the materials testing. The American Association recognizes Becker Laboratory for Laboratory Accreditation (A2LA) for compliance with ISO 9001, *Quality Systems - Model for Quality Assurance in Design, Development, Production, Installation and Servicing*. All samples handling and testing at Patuxent River laboratory is ISO 9001 compliant. Appendix D, Tables D-1, D-2, and D-4 outline the test methods.

For materials testing, there were no major deviations or modifications from standard methods for either laboratory analysis or field-testing. Any significant deviations from the standard sampling or analytical protocols are described in Section 5. Material performance was judged against control coatings plated from hard chromium solutions without WA/FS. Performance, equivalent or better than controls is required for implementation. QQ-C-320B provides allowable performance limits for each test. Fatigue values are based on NAVAIR Structures Division requirements and data from other sources such as the development of HVOF Coating.

5. Performance Assessment

5.1 Performance Data

There are five types of performance data that were developed in conjunction with this study:

- Surface tension
- stack emission data (i.e., chromic acid mist ventilated to the environment outside the shop)
- IH data (i.e., chromic acid mist in the areas surrounding the plating bath),
- Data relating to the material quality of the parts electroplated while WA/FS was in use
- Other data, such as the amount of WA/FS constituents in the stack emissions and scrubber wastewater.

These data are presented and described in the following sections.

5.1.1 Surface Tension

Surface tension measurements were taken to approximate the requirements for a new bath as discussed in Section 2.1.2.2, *Design Criteria*. For three of the days at NADEP Cherry Point and one day at Tinker AFB the chromium electroplating baths were in the “baseline” condition (about 72 dynes/cm) (i.e., no WA/FS was added to the baths). For the other days, the baths contained WA/FS at concentrations sufficient to adjust the surface tension of the baths to between 23 and 34 dynes/cm. The target surface tension for test conditions was below 30 dynes/cm.

5.1.2 Stack Emissions Data

Stack emissions were sampled and analyzed on 8 separate days at NADEP Cherry Point, and 6 days at Tinker AFB. Three 2-hour samples were extracted from the exhaust ductwork during each sampling day. The results of those sampling events are summarized in Table 5-1 in terms of milligrams of both hexavalent and total chromium per dry standard cubic meter of air (mg/dscm). In addition, Figures 5-1 and 5-2 graphically present the sampling results. For comparison purposes, the current USEPA NESHAP for hard chromium electroplating, for shops larger than 60 million ampere-hours per year (which all DOD shops are expected to be) is 0.015 mg/dscm. (The limit for *decorative* chromium shops is 0.01 mg/dscm **or** a surface tension of less than 45 dynes/cm) All of the sampling and analysis data from each day of testing at NADEP Cherry Point are summarized in Tables D-4 through D-9 in Appendix D. For Tinker AFB each day's testing data are summarized in Tables D-10 through D-14.

The only significant deviation from Method 306 test requirements occurred during the testing at NADEP Cherry Point on 15 and 16 Nov 00. For all six of those test runs the isokinicity of the tests were out of desired 90 to 110 percent range. The isokinicity for those six tests ranged from 81.7 to 85.0 percent. A foreign particle became lodged in the gas flow tubing after the sampling

equipment had been calibrated by CAE (the equipment owner), but prior to the test. For all other testing, at both NADEP Cherry Point and Tinker AFB, isokinicity was 91.9 to 103.1 percent.

Additionally, it was noted that a basement door was opened during the glassware rinsing phase of the second stack test at NADEP Cherry Point on 27 Mar 01. At that time a significant breeze blew constantly through the sampling and rinsing area. The chromium concentration data for the second test on that day is higher than the other two tests (0.0539 mg/dscm as opposed to 0.0356 and 0.0349). This higher reading may have been influenced by chromium-containing dust contaminating the samples during rinsing.

Table 5 – 1. Summary of Chromium Concentrations in Stack Emissions (mg/dscm)

NADEP CHERRY POINT

| Sampling Date | Surf. Tension (dynes/cm) | Hexavalent Chromium | | | | Total Chromium | | | |
|---------------|--------------------------|---------------------|------------|------------|---------|----------------|------------|------------|---------|
| | | Sample # 1 | Sample # 2 | Sample # 3 | Average | Sample # 1 | Sample # 2 | Sample # 3 | Average |
| 7/11/00 | 72 | <i>n/a</i> | 6.32 | 0.737 | 3.529 | <i>n/a</i> | 6.804 | 0.853 | 3.829 |
| 7/12/00 | 72 | 3.13 | 0.912 | 1.37 | 1.804 | 4.06 | 0.919 | 1.56 | 2.180 |
| 9/21/00 | 33 | 0.0418 | 0.0299 | 0.0216 | 0.0311 | 0.0482 | 0.0367 | 0.0237 | 0.0362 |
| 11/15/00 | 76 | 1.49 | 1.30 | 1.26 | 1.35 | 1.57 | 1.31 | 1.21 | 1.36 |
| 11/16/00 | 23.1 | 0.0446 | 0.0482 | 0.0678 | 0.0535 | 0.0431 | 0.0473 | 0.0678 | 0.0527 |
| 12/13/00 | 23.4 | 0.0170 | 0.0273 | 0.0233 | 0.0225 | 0.0193 | 0.0289 | 0.0243 | 0.0242 |
| 3/27/01 | 27 | 0.0313 | 0.0533 | 0.0276 | 0.0374 | 0.0356 | 0.0539 | 0.0349 | 0.0415 |
| 4/17/01 | 27 | 0.0215 | 0.0153 | 0.0204 | 0.0191 | 0.0218 | 0.0163 | 0.0209 | 0.0197 |

| | | |
|-------------------------------|---------------|---------------|
| Average Without WA/FS: | 2.228 | 2.457 |
| Average with WA/FS: | 0.0327 | 0.0348 |

NOTE: n/a indicates that no parts were being electroplated during test number 1 on 11 July 00

TINKER AFB

| Sampling Date | Surf. Tension (dynes/cm) | Hexavalent Chromium | | | | Total Chromium | | | |
|---------------|--------------------------|---------------------|------------|------------|---------|----------------|------------|------------|---------|
| | | Sample # 1 | Sample # 2 | Sample # 3 | Average | Sample # 1 | Sample # 2 | Sample # 3 | Average |
| 9/12/00 | 72 | 0.516 | 0.286 | 0.347 | 0.3833 | 0.645 | 0.333 | 0.443 | 0.474 |
| 10/11/00 | 34 | 0.00818 | 0.0104 | 0.00624 | 0.0083 | 0.00890 | 0.0125 | 0.0111 | 0.0108 |
| 11/8/00 | 27 | 0.00870 | 0.00715 | 0.00295 | 0.00627 | 0.00896 | 0.00642 | 0.00299 | 0.00612 |
| 12/6/00 | 30.5 | 0.0234 | 0.0186 | 0.0106 | 0.0175 | 0.0240 | 0.0215 | 0.0125 | 0.0193 |
| 7/31/01 | 27.5 | 0.106 | 0.0204 | 0.0337 | 0.0534 | 0.109 | 0.0217 | 0.0397 | 0.0568 |
| 8/1/01 | 27.5 | 0.0242 | 0.0314 | 0.0242 | 0.0266 | 0.0271 | 0.0344 | 0.0262 | 0.0292 |

| | | |
|-------------------------------|---------------|---------------|
| Average without WA/FS: | 0.383 | 0.474 |
| Average with WA/FS: | 0.0224 | 0.0245 |

NOTE: *Italicized and shaded* rows represent baseline sampling (i.e., without WA/FS).

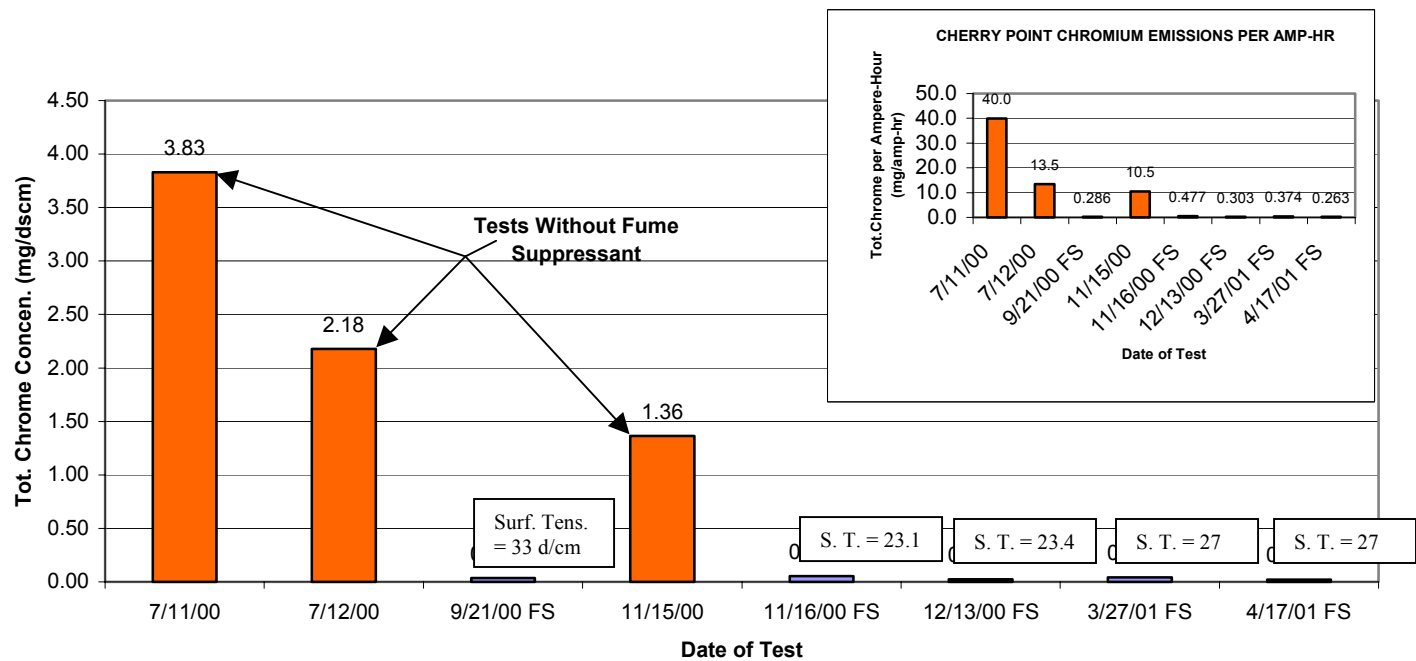


Figure 5-1. NADEP Cherry Point total chromium emissions concentration.

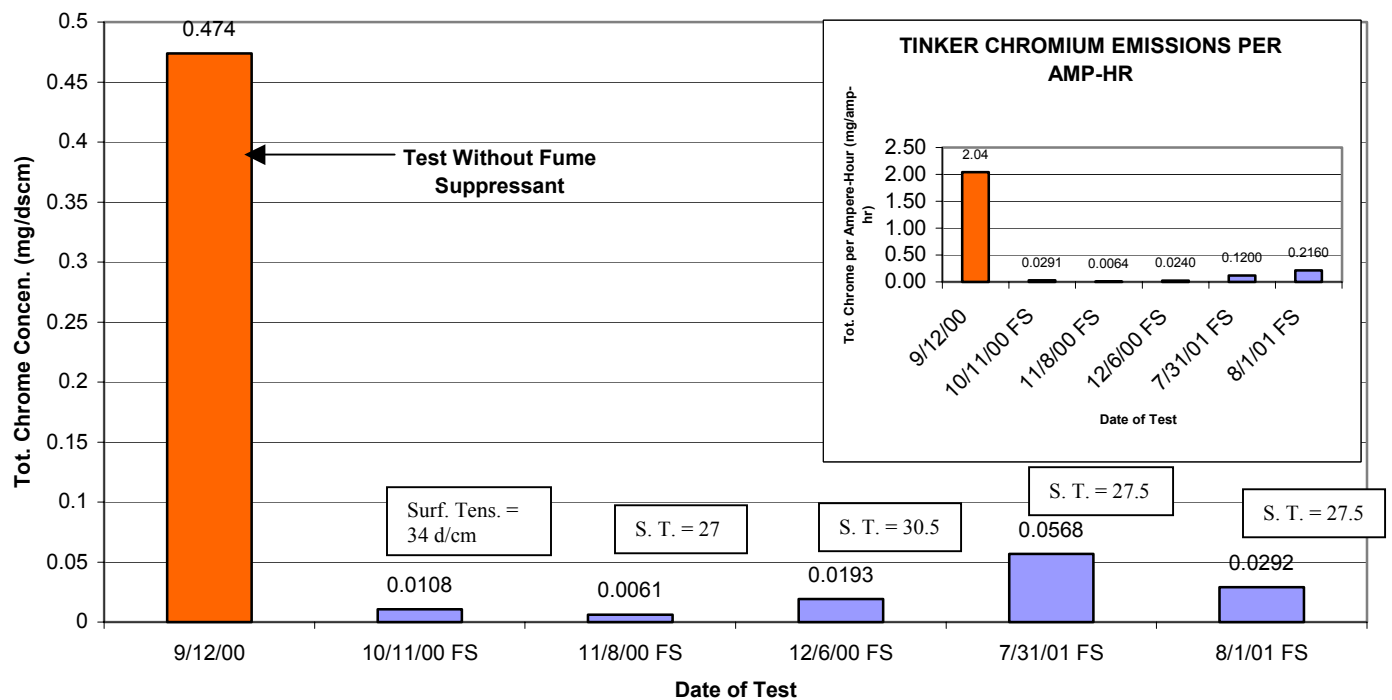


Figure 5-2. (AFB Tinker) total chromium emissions concentration.

5.1.2.1 *WA/FS Effectiveness and Level of Compliance*

It becomes immediately obvious, when reviewing the summary data in Table 5-1 and Figures 5-1 and 5-2 that using WA/FS causes a dramatic decrease in the concentration of total and hexavalent chromium from stack emissions. At NADEP Cherry Point the average reduction in concentration of total chromium was about 70-fold. At Tinker AFB it was about 20-fold.

However, when comparing the emissions data to the current USEPA NESHAP standard of 0.015 mg/dscm, the NADEP Cherry Point average data with WA/FS for total chromium is 0.0348 mg/dscm, and the Tinker AFB average data with WA/FS for total chromium is 0.0245 mg/dscm. Both would be out of compliance if they did not have APCDs downstream of the sampling points.

Pacific Environmental Services (PES) also performed stack sampling at the NADEP North Island facility in December 2000. Those data show that the average of two 2-hour stack tests *with* WA/FS in the electroplating bath, taken *upstream* of their air scrubber, were 1.7 mg/dscm of hexavalent chromium (a much higher concentration than the NADEP Cherry Point and Tinker AFB data taken with WA/FS). The average of three 2-hour tests *with* WA/FS, *downstream* of their scrubber was 0.00097 mg/dscm. The downstream results are not comparable to the NADEP Cherry Point and Tinker AFB data though, because the emissions downstream of the scrubber represent not only the effect of WA/FS, but also the effect of the air scrubber.

Data are also presented in graphs in the upper right-hand corners of Figures 5-1 and 5-2 for the emissions as a function of the electroplating load (i.e., mg of chromium per ampere-hour (mg/amp-hr)). The results are also dramatic with respect to the reduction in emissions with WA/FS as compared to without WA/FS. For Tinker AFB there is some question about whether the amp-hr meters were providing the correct readings. Therefore, some of the ampere-hour emissions data for Tinker AFB may be incorrect.

5.1.2.2 *Hexavalent Versus Total Chromium*

There has been controversy in the scientific community with respect to what portion of the emissions from hard and decorative hexavalent chromium-based electroplating is hexavalent chromium. Both total and hexavalent chromium were reported for each stack test in this study. The data show that 57 percent of the tests had hexavalent chromium concentrations that were greater than 90 percent of the total chromium concentration. Thirty-one percent of the tests had hexavalent chromium concentrations that were between 80 and 90 percent of the total chromium concentrations. For the remaining 12 percent of the tests hexavalent chromium was less than 80 percent of the total. Note that analysis of plating bath contents performed on two baths at NADEP Cherry Point, two baths at Tinker AFB, and one bath at North Island, show that the chromium in the plating baths is essentially 100 percent hexavalent chromium (see Section 5.1.5.2).

5.1.2.3 *The Influence of Exhaust Volume and Velocity*

It can be noted from Table 5-1 that the emissions at NADEP Cherry Point are generally a higher concentration than those at Tinker AFB (about 5 times higher without WA/FS in the bath, and about 1.5 times higher with WA/FS). Table 5-2 compares: the surface areas of the baths that were tested at each site (square feet); the average exhaust flow (dry standard cubic feet per minute); the freeboard (inches), the area of the exhaust intakes (square feet); the average exhaust volume per unit of bath surface area (cubic feet per minute per square foot); the average exhaust intake velocity (feet per minute); chromium concentration in the plating bath (percent); and, exhaust configuration.

Analysis of Table 5-2 does not lead to any definitive explanation for the difference in concentrations of chromium in the exhaust at NADEP Cherry Point versus Tinker AFB. Table 5-2 does however, show the following relationships: (1) the exhaust volume at Tinker AFB averages 13 percent higher than NADEP Cherry Point, suggesting additional dilution at Tinker AFB, and (2) the concentration of hexavalent chromium in the bath at Tinker AFB is about 17 percent lower than the bath at NADEP Cherry Point (at least on the days that the single samples were taken from each bath). Both these facts would support the observed higher concentration of chromium in the exhaust at NADEP Cherry Point (but not nearly as high as the differences described in the above paragraph). However, one might also assume that the exhaust system at NADEP Cherry Point does not capture fumes as effectively as Tinker AFB because there is only one lip vent at NADEP Cherry Point, and because the exhaust intake velocity is lower at NADEP Cherry Point. This would lead one to conclude that there should be a lower concentration of emissions at NADEP Cherry Point than at Tinker AFB.

Table 5-2. Influence of Exhaust Parameters on Emissions Concentration

| | Bath Surface Area (ft ²) | Average Exhaust Volumetric Flow (dscfm) | Freeboard (inches) | Exhaust Intake Area (ft ²) | Exhaust Volume per Unit Surface Area (cfm/ft ²) | Exhaust Intake Velocity (fpm) | Hexavalent Chromium Concent. in Bath (%) | Exhaust Configuration |
|---------------------------|--------------------------------------|---|--------------------|--|---|-------------------------------|--|---|
| NADEP Cherry Point | 21.5 | 6,350 | 8 | 3.22 | 295 | 1,970 | 15.1 | "Pull"-only system. One lip vent on back (long side), with back wall. |
| Tinker AFB | 26.8 | 7,160 | 7-1/2 | 2.65 | 267 | 2,700 | 12.6 | "Pull"-only system. One lip vent on each long side. Stand-alone bath. |

5.1.3 Industrial Hygiene (IH) Data

Table 5-3 presents the data from IH engineering sampling. IH samples were taken concurrently with the stack testing at NADEP Cherry Point and Tinker AFB. Samples were taken in three locations: (1) a few inches directly above the sampled bath liquid surface (“In Tank”), (2) directly in front of the sampled bath near the breathing zone (“Near Tank Breathing Zone”), and (3) a few feet from the sampled bath near the breathing zone (“Remote Breathing Zone”). It would be anticipated that the most concentrated samples would be those taken above the liquid surface, and that the least concentrated would be those “remote” samples taken a few feet from the bath. In fact this was the general trend for all testing *except* at Tinker AFB during the baseline tests (i.e., tests without WA/FS in the bath).

Each value in Table 5-3 represents an average of two data points unless otherwise noted. Shaded values represent baseline samples (i.e., when no WA/FS was in the bath). Average concentrations for all testing are shown at the bottom of Table 5-3, both for the baseline condition, and when the baths contained WA/FS. As noted above, the trend is clear from the averages that the hexavalent chromium concentrations decrease as the sampling location becomes more remote (except for the baseline testing at Tinker AFB). Discussions with industrial hygienists indicate that these outliers do occur in plating operations. One explanation is that the spray rinsing operation splashes chromium laden water droplets on the sample cassette.

It is also clear that the concentrations of chromium are much less when WA/FS is in use than when it is not (again with the exception at Tinker AFB for samples taken in the breathing zone near the bath). In fact, for the samples taken a few inches from the liquid surface (“In Tank”), the improvement when WA/FS is in use is more than 20-fold. It is theorized that the improvement is not as dramatic at the breathing zone locations (and is in fact reversed for the noted Tinker AFB “Near Tank” samples) because the concentrations are very low at those locations to begin with, such that the influence of other facility chromium-containing baths is significant. In fact, all concentrations of hexavalent chromium measured during IH sampling were far below the current OSHA Permitted Exposure Limit (PEL) of $52\text{ }\mu\text{g}/\text{m}^3$ (as chromium), even those taken directly over the liquid surface. With respect to the most stringent *anticipated* OSHA standard of $0.50\text{ }\mu\text{g}/\text{m}^3$, the only samples that exceeded that proposed standard were samples taken directly over the liquid surface when WA/FS was not in use (i.e., the baseline condition).

As noted above, the trends are reasonably clear that (1) using WA/FS lowers occupational exposure to hexavalent chromium, and that (2) the further away one gets from the tank surface, the lower the hexavalent chromium shop air concentration becomes. The notes on Table 5-3 indicate that there were four very high concentration “outlier” analyses that were excluded when averaging the results (notes 3, 4 5, and 8). These outliers were 3.59, 585, 31.52, and $28.6\text{ }\mu\text{g}/\text{m}^3$, respectively. If only the $585\text{ }\mu\text{g}/\text{m}^3$ value were excluded from Table 5-3, rather than all four values, the trends become even more dramatic. The results of including all but the $585\text{ }\mu\text{g}/\text{m}^3$ value can be seen in Appendix G, which is the modified version of Table 5-3.

Table 5-3. INDUSTRIAL HYGIENE SAMPLING DATA - also see NOTES
(concentrations in micrograms/cubic meter)

| NADEP CHERRY POINT | | | | TINKER AFB | | | |
|------------------------------|-----------------------------------|--------------------------|--------------|-----------------|-----------------------------------|--------------------------|----------------|
| Test Date | Hexavalent Chromium Concentration | | | Test Date | Hexavalent Chromium Concentration | | |
| | Remote Breathing Zone | Near Tank Breathing Zone | In Tank | | Remote Breathing Zone | Near Tank Breathing Zone | In Tank |
| 7/11/00 | 0.041 | 0.038 (note 3) | 1.450 | 9/12/00 am | 0.115 | 0.014 (note 5) | 0.201 (note 4) |
| 7/12/00 | 0.033 | 0.077 | 1.250 | 9/12/00 pm | (note 6) | 0.022 | 0.252 |
| 9/21/00 am | 0.031 | 0.024 | 0.023 | 10/11/00 am | 0.007 | 0.035 | 0.023 |
| 9/21/00 pm | (note 6) | 0.043 | 0.043 | 10/11/00 pm | (note 6) | 0.028 | 0.033 |
| 11/15/00 am | 0.056 | 0.112 | 2.266 | 11/8/00 am | 0.047 | 0.014 | 0.036 |
| 11/15/00 pm | (note 6) | (note 6) | 2.400 | 11/8/00 pm | (note 6) | (note 6) | 0.078 |
| 11/16/00 am | 0.042 | 0.035 | 0.070 | 12/6/00 | 0.028 | 0.042 | 0.100 |
| 11/16/00 pm | (note 6) | (note 6) | 0.120 | 7/31/01 | 0.023 | 0.038 | 0.053 |
| 12/13/00 am | 0.014 | 0.030 | 0.113 | 8/1/01 (note 7) | 0.050 | 0.018 | 4.23 (note 8) |
| 12/13/00 pm | (note 6) | 0.030 | 0.075 | | | | |
| 3/27/01 | 0.014 | 0.186 | 0.073 | | | | |
| 4/17/01 | 0.028 | 0.014 | 0.041 | | | | |
| Averages⁹: | | | | | | | |
| Without FS: | 0.043 | 0.076 | 1.68 | | 0.083 | 0.018 | 2.23 |
| With FS: | 0.026 | 0.060 | 0.067 | | 0.026 | 0.031 | 0.060 |

NOTES:

- 1 – Rows with shaded background represent baseline data (i.e., without fume suppressant [FS]).
- 2 – All values reported below various detection limits were averaged as the detection limit divided by the square root of 2 (i.e., 1.414).
For example: if non-detect was less than 0.020 mic/cu.m. then it was reported as 0.014 (i.e., 0.020/1.414) – see reference 5.
- 3 – For NADEP Cherry Point, a value of 3.59 mic/cu.m. was considered an outlier from the 7/11/00 sampling for "Near Tank Breathing Zone", and was not included in the calculations.
- 4 – For Tinker AFB, a value of 585 mic/cu.m. was considered an outlier from the 9/12/00 am sampling for "In Tank",
And was not included in the calculations.
- 5 – For Tinker AFB, 9/12/00 am, "Near Tank Breathing Zone", two locations were sampled. One of the locations had a concentration of 31.52 mic/cu.m. This value was considered an outlier, and was not included in calculations.
- 6 – To reduce the likely hood of obtaining non-detected results and collect more material on the cassette, only one set of samples was taken during the day, spanning the entire day (i.e., am plus pm). The value shown for "am" represents the entire day.
- 7 – This baseline sample was taken on Tank 214. All other data were for Tank 222.
- 8 – For Tinker AFB, 8/1/01, "In Tank", two locations were sampled. One of the locations had a concentration of 28.6 mic/cu.m. This value was considered an outlier, and was not included in the calculations.
- 9 – To calculate averages, concentrations based on a full-day sampling were given twice the weight as concentrations based on half-day sampling.

For REFERENCE:

- 1 – Occupational Safety and Health Administration (OSHA) Permissible Exposure Limit (PEL) is 100 Micrograms per cubic meter (mic/cu.m.) as chromic oxide (52 mic/cu.m. as chromium).
- 2 – **Proposed** OSHA PEL ranges between 0.5 and 5 mic/cu.m.
- 3 – American Conference on Governmental Industrial Hygienists (ACGIH) Time Weighted Average (TWA) for Water-soluble hexavalent chromium compounds is 50 mic/cu.m. as chromium.
- 4 – National Institute for Occupational Safety and Health (NIOSH) Recommended Exposure Limit (REL) for Hexavalent chromium compounds is 1 mic/cu.m. as chromium.
- 5 – Navy Environmental Health Center (NEHC), Industrial Hygiene Field Operations Manual, Chapter 4, Section 8a.(3), page 4-22⁹

5.1.4 Mechanical Quality Data

The following types of testing were performed on samples of steel that were hard chromium electroplated both with and without WA/FS:

- Hydrogen embrittlement
- Hardness
- Porosity
- Adhesion
- Thickness
- Fatigue

Details and results of each testing protocol are discussed and summarized below.

5.1.4.1 Hydrogen Embrittlement

The ability of a hard chromium coating to allow for a post-electroplating bake to drive hydrogen from the embrittlement-sensitive steel is critical for implementation. This test is to validate whether the addition of Fumetrol® 140 to the plating solution affects the as-plated, as-baked tensile performance of high-strength steels. Hydrogen embrittlement testing was performed on ASTM F 519 Type 1a.1 notched round bars made from 4340 steel (see Figure 5-3). Bars were chromium plated at all three facilities (NADEP Cherry Point, Tinker AFB, and NADEP North Island) while using Fumetrol® 140 and from NADEP Cherry Point and Tinker AFB with no Fumetrol 140® (controls).

Two types of testing were performed. The first was the standard 200-hour sustained tensile load test per AMS QQ-C-320 as defined in ASTM F 519 (75 percent of ultimate tensile strength [UTS] for 200 hours). The second test was a developmental rising step load (RSL) test that holds the specimen at 75 percent of UTS test for 24 hours, followed by 5 percent step tensile increases each hour to failure. This new procedure is designed to provide feedback on process quality in about 24 hours versus the standard technique that takes 8 days and is impractical for cost-effective production decisions.

Appendix H details results of the sustained tensile load test completed by Dirats Laboratories as well as results of the rising step load tests completed at NAVAIR Patuxent River. Most importantly, all specimens from all sites and tanks passed the 200-hour sustained tensile load test, indicating that Fumetrol® 140 has no deleterious effect on the embrittlement characteristics of high-strength steels plated with hard chromium. For comparison purposes, all test samples survived the initial 24-hour sustained load of the RSL test (not unexpected due to the success in the 200-hour test) and all samples fractured at an average of between 89.5 and 93.2 percent of UTS. Although there appears to be no statistical difference in performance, the specimens plated from Fumetrol® 140 tanks broke at slightly higher UTS levels. Table 5-4 shows the comparison of the average fracture strengths for each site with and without Fumetrol® 140.



Figure 5-3. Notched round bar for hydrogen embrittlement testing.

Table 5-4. Average Fracture Strengths (Fracture Percent) for RSL Notched Round Bars

| NADEP Cherry Point w/o Fumitrol | NADEP Cherry Point w/Fumitrol | North Island w/o Fumitrol | Tinker AFB w/o Fumitrol | Tinker AFB w/Fumitrol |
|--|--------------------------------------|----------------------------------|--------------------------------|------------------------------|
| 92.6 | 92.8 | 91.0 | 93.7 | 93.8 |
| 87.8 | 91.4 | 93.6 | 94.3 | 93.3 |
| 91.2 | 89.0 | 91.4 | 91.5 | 93.8 |
| 90.0 | 90.2 | 94.2 | 93.0 | 94.7 |
| 92.3 | 92.7 | 91.1 | 92.3 | 93.3 |
| 90.2 | 89.5 | 92.7 | 93.7 | 90.2 |
| 93.1 | 90.2 | 93.2 | 93.0 | 93.3 |
| 92.2 | 94.1 | 93.2 | 93.5 | 92.8 |
| 74.0 | 93.2 | 93.1 | 90.6 | 93.8 |
| 90.0 | | 90.1 | | |
| 90.7 | | | | |
| 89.5 | 91.5 | 92.4 | 92.8 | 93.2 |

5.1.4.2 Hardness

Per AMS QQ-C-320, the Vickers Hardness test method was planned to be used to determine coating hardness. Due to the availability of hardness testing equipment, the materials test laboratory at NADEP Cherry Point performed the hardness test using their standard technique based on the Rockwell C method. Per Table 5-5, three samples from NADEP Cherry Point and Tinker AFB with and without Fumetrol® 140 were chosen at random from a batches of 1- by 4-inch test coupons. Each of the samples had 10 hardness tests performed on it. Table 5-5 presents the hardness data using the Rockwell C scale.

Table 5-5. Hardness Tests

| Sample | Source | Hardness (Rockwell C) | | | | |
|--------|-------------------------------|-----------------------|-------------------------|--------------------|-------|-------|
| | | Average of 10 Tests | Average of the Averages | Standard Deviation | Max | Min |
| 1 | NADEP Cherry Point- no WAFS | 63.68 | | 2.86 | 67.16 | 57.70 |
| 2 | NADEP Cherry Point- no WAFS | 60.01 | 62.82 | 3.45 | 65.23 | 53.13 |
| 3 | NADEP Cherry Point- no WAFS | 64.78 | | 2.12 | 67.36 | 60.81 |
| 1 | NADEP Cherry Point- with WAFS | 63.19 | | 1.38 | 64.95 | 61.04 |
| 2 | NADEP Cherry Point- with WAFS | 61.56 | 63.02 | 2.86 | 64.10 | 54.43 |
| 3 | NADEP Cherry Point- with WAFS | 64.31 | | 4.09 | 67.36 | 53.13 |
| 1 | Tinker AFB – no WA/FS | 64.12 | | 1.084 | 65.24 | 61.93 |
| 2 | Tinker AFB – no WA/FS | 64.74 | 64.07 | 1.105 | 67.00 | 63.13 |
| 3 | Tinker AFB – no WA/FS | 63.35 | | 2.413 | 66.41 | 58.84 |
| 1 | Tinker AFB – with WA/FS | 63.77 | | 0.963 | 64.95 | 61.93 |
| 2 | Tinker AFB – with WA/FS | 64.27 | 63.91 | 0.932 | 65.53 | 62.55 |
| 3 | Tinker AFB – with WA/FS | 63.68 | | 0.873 | 64.66 | 61.93 |

Based on the data, there appears to be no statistical difference between the results with or without Fumetrol® 140. Therefore, the use of Fumetrol® 140 in hard chromium electroplating baths has no detrimental effect on the hardness of the plated part. An additional set of tests was run on three samples from the North Island facility, but only with Fumetrol® 140. The results were similar to the Tinker AFB and NADEP Cherry Point data.

5.1.4.3 Porosity

The porosity/pitting test detailed in AMS QQ-C-320 provides a relative measure of the quality of the electroplated chromium. Since previous generations of fume suppressants increased the porosity of the electroplated chromium, this is an important test to validate the performance of Fumetrol® 140 relative to previous products and the control tanks.

Initial porosity testing was completed on three samples each from NADEP Cherry Point and Tinker AFB with and without Fumetrol® 140, and three samples from North Island. Each sample was a 1" by 4" 4130 steel coupon plated with a 1-mil thick chromium coating. The 1- by 4-inch coupon size was used instead of the 3- by 10-inch size detailed by the specification due to processing restraints. For the ferroxyl test, AMS QQ-C-320 allows for 1 pit per 10 square inches of test surface.

Of the test sets, only the NADEP Cherry Point set processed from the control tank with no Fumetrol® 140 showed no pits, and passed the specification criteria. The Fumetrol® 140 set from NADEP Cherry Point showed small numbers of pits but also appeared to have red rust on the surface of the chromium from processing. This rust may have been deposited from the unplated areas of the test coupons that were in contact with the chromium plating. All coupons from Tinker AFB (with and without Fumetrol® 140) had residual red rust on the chromium surface as well, presumably leading to the large number of pits seen. For the North Island set, two coupons were pit-free and one had four pits. As a result of the initial tests, there is no evidence that the Fumetrol® 140 changes the porosity of the chromium plating. Because so many coupons did show positive results, it was decided to run another set of tests using thicker coatings and NADEP Cherry Point as the coating source.

For this test, the chromium was plated to 3 mils thick for both control and Fumetrol® 140 coatings. The ferroxyl test was completed on five specimens of each coating. Figures 5-4 through 5-6 show the results of the test for the control (i.e., without Fumetrol® 140) and with Fumetrol® 140.



Figure 5-4. Porosity test of hard chromium from tank without Fumetrol® 140 (NADEP Cherry Point)

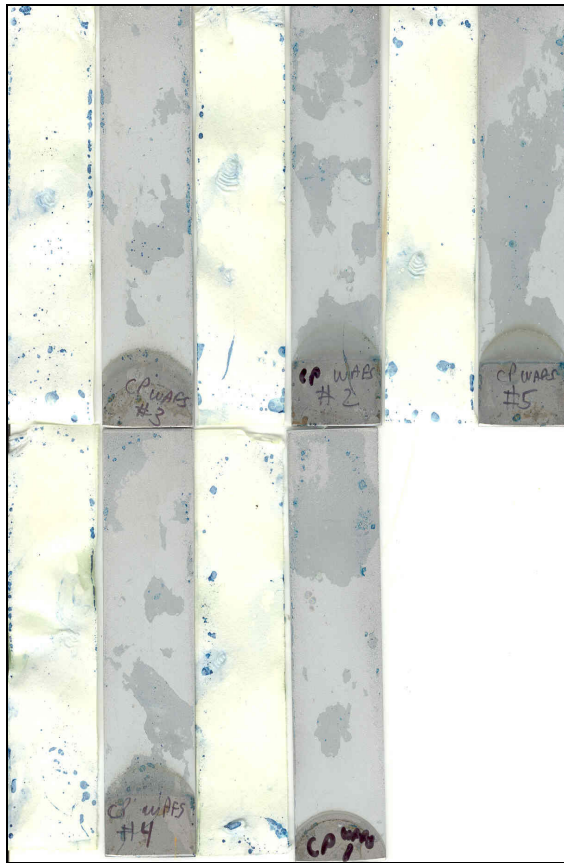


Figure 5-5. Porosity test of hard chromium from tank with Fumetrol® 140 (NADEP Cherry Point)

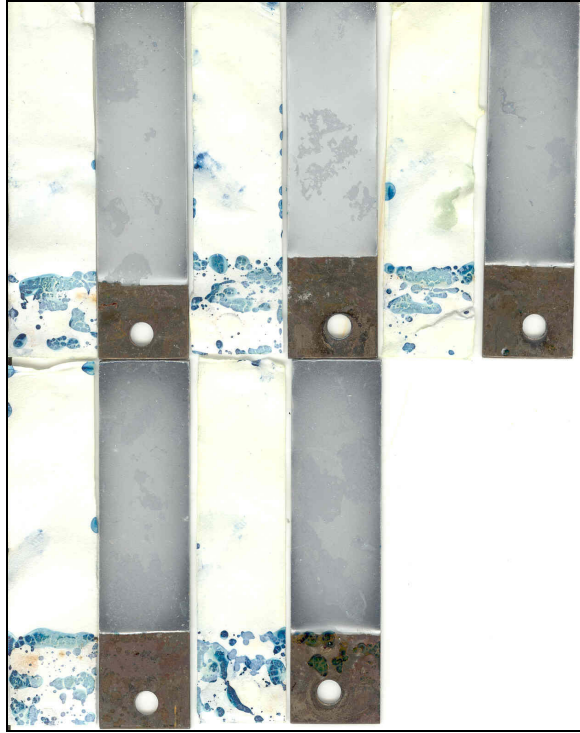


Figure 5-6. Porosity test of hard chromium from tank with Fumetrol® 140 (North Island)

No difference in porosity was noted between the NADEP Cherry Point-plated coatings with and without Fumetrol® 140 in the plating tanks. The overall porosity of the NADEP North Island coatings from a plating tank with Fumetrol® 140 was less than the NADEP Cherry Point coatings. As a result, there appears to be no deleterious effect on porosity due to the presence of Fumetrol in the plating tanks.

5.1.4.4 *Adhesion*

A bend-to-break adhesion test was used to evaluate the quality of adhesion of the chromium to the substrate and the potential effect of Fumetrol® 140 on adhesion. Five random samples of the original sets of 1-mil thick coatings from NADEP Cherry Point (with and without Fumetrol® 140), Tinker AFB (with and without Fumetrol® 140), and North Island (with Fumetrol® 140) were tested. All samples from NADEP Cherry Point and Tinker AFB passed the test in that no loss of adhesion was noted after breaking. The North Island samples showed a small degradation in adhesion that was linked to a quality control problem and resolved.

The test was repeated using five random 3-mil thick coatings from NADEP Cherry Point as described in Section 5.1.4.3. No samples showed any degradation in adhesion. As a result, Fumetrol® 140 is considered not to have an effect on coating adhesion compared to the control coating. Figure 5-7 shows a series of 3-mil thick test specimens.

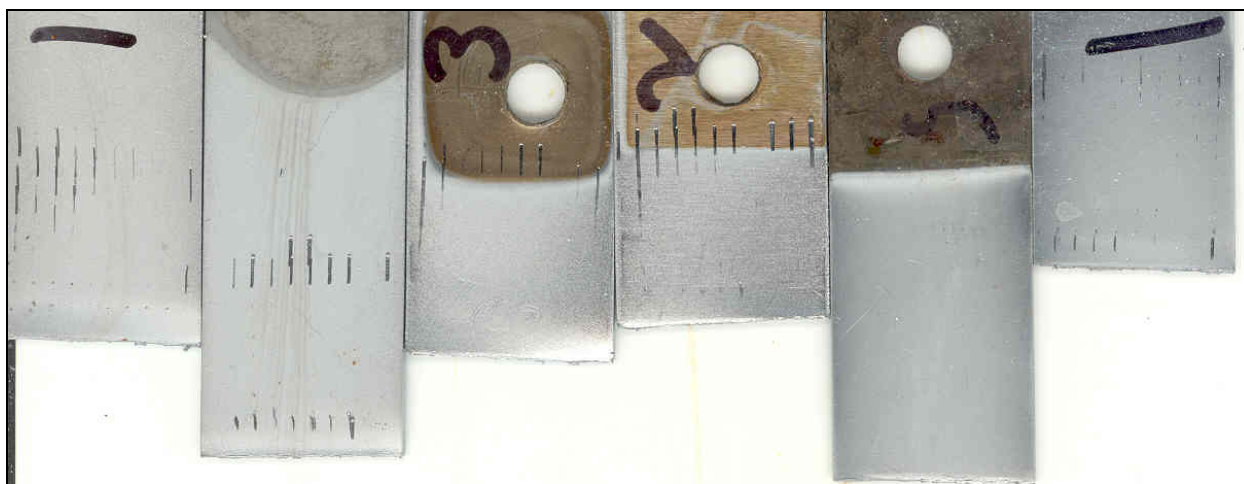


Figure 5-7. Adhesion specimens subjected to bend-to-break test

5.1.4.5 Thickness

Thickness is not a pass/fail criterion and detailed here to show that the coatings are close to the requested thickness and regular from sample to sample. Table 5-6 details coating thicknesses for samples from each lot of coating for the second round of testing. For each coupon, the thickness shown is an average of three measurements.

Table 5-6. Average Thicknesses of Hard Chromium Coatings (mils)

| Coupon | NADEP North Island with Fumetrol | NADEP Cherry Point with Fumetrol | NADEP Cherry Point w/o Fumetrol(control) |
|---------|----------------------------------|----------------------------------|--|
| 1 | 2.4 | 3.5 | 2.6 |
| 2 | 2.7 | 2.5 | 2.2 |
| 3 | 2.5 | 3.5 | 2.3 |
| 4 | 2.6 | 3.0 | 1.9 |
| 5 | 2.5 | 3.0 | 0.65 |
| Average | 2.5 | 3.1 | 1.9 |

5.1.4.6 Fatigue

The potential influence of Fumetrol® 140 on the fatigue characteristics of representative high-strength steels was evaluated by a Limited Equivalence Test as detailed in Appendix F. Also shown in Appendix F are drawings of Fatigue Test Specimens. Three alloys were selected based on their use and importance in DOD on critical components:

- 300M (per AMS 6419)
- Aermet 100 (per AMS 6532)
- 13-8 (H1000) (per AMS 5629)

Fatigue specimens were designed and machined out of these alloys per ASTM E 466 and ASTM E 606 and supplied by Metcut. Appendix F details the specifications of coupons designed for low and high-cycle axial fatigue tests and the strength levels as manufactured. After receipt from Metcut, the coupons were sent to NADEP Cherry Point for electroplating of hard chromium from a control production tank with no fume suppressant and a test tank with Fumetrol® 140. All test coupons were plated to 0.003 inch (3 mils) of hard chromium per NADEP Cherry Point's normal procedure and subsequently baked for 24 hours at 190°C to remove hydrogen from the specimens. NADEP Cherry Point then shipped the plated test specimens back to NAS Patuxent River for fatigue testing.

Specimens were tested in the NAVAIR Materials Mechanical Test Laboratory to the loads and fatigue spectra as detailed in Appendix F. Analysis of the data indicates that the Fumetrol® 140 has no, or a slightly positive, effect on fatigue performance of the test specimens.

5.1.4.7 Material Effects of Fumetrol 140- Conclusion

Based on the empirical data from NADEP North Island's use of Fumetrol® 140 for more than 5 years and the data generated by this project, it appears that Fumetrol® 140, when used in accordance with the testing in this project, has no deleterious effect on the hard chromium plating or steel substrates on which it is electroplated.

5.1.5 Other Data

5.1.5.1 Perfluorooctyl Sulfonate (PFOS) Releases to the Environment

According to its Material Safety Data Sheet (MSDS), organic fluorosulfonates (OFS) are the primary active component in the Fumetrol® 140 WA/FS additive used in this study to reduce emissions of chromium mist from the hard chromium electroplating baths that were tested. (The MSDS states that from 1 to 7 percent of the constituents are OFS.) One type of OFS compounds, perfluorooctane sulfonates (PFOS), is regulated by USEPA under a Significant New Use Rule (SNUR) (see Section 7.0). Fumetrol® 140 is added to the electroplating bath at about 0.25 percent by volume, and because no more than 7 percent of the Fumetrol® 140 can be PFOS compounds, there can be no more than about 0.0175 percent of PFOS compounds in the bath. It is unlikely that USEPA will ultimately regulate the use of PFOS compounds at these low levels. The regulation appears to target the primary use of PFOS compounds, which is the treatment of fabrics and paper to provide soil and water resistance.

Nevertheless, during this study one composite stack sample was analyzed for OFS constituents, including PFOS compounds. (The composite consisted of equal parts of the filtered liquid samples from each of the three stack tests performed on 31 July 2001 at the Tinker AFB site.) In addition a sample of the water in the air scrubber effluent holding tank at Tinker AFB was taken

to see if the scrubber water blowdown to Tinker AFB's industrial wastewater treatment plant (IWTP) contained PFOS compounds. A sample was also taken of the wastewater influent to the IWTP, which includes the aforementioned scrubber blowdown as well as other industrial wastewaters. Table 5-7 shows the analytical results for these samples. Only two of the 16 analyzed-for organic perfluoride compounds were detected in any of the samples. (The detection limit for the OFS compounds of concern was 10 micrograms per liter [$\mu\text{g/l}$], which is the same as 10 parts per billion [ppb]). These were both PFOS compounds. The liquid sample from the stack test contained perfluorooctane sulfonate (one of the PFOS compounds) at a level that equates to 0.0049 mg/dscm in the air emissions to the scrubber. The other PFOS compound detected was 2-(N-ethylperfluorooctanesulfonamido) ethyl alcohol (PFOSA), at 0.0013 mg/dscm. In addition, perfluorooctane sulfonate was found in the scrubber effluent holding tank at 11 $\mu\text{g/l}$. No PFOS compounds were detected in the IWTP influent. This is not unexpected, since the effluent sample is highly diluted. A blank sample was also tested, and 11 $\mu\text{g/l}$ of PFOSA were detected. Consequently, one might assume that the PFOSA detected in the liquid sample from the stack test did not really contain any PFOSA.

Table 5-7. Perfluorooctyl Sulfonates (PFOS) Analyses

| PFOS Compound | Stack Test Liquid Sample ($\mu\text{g/l}$) | Equivalent Stack Emissions to Scrubber (mg/dscm) | Scrubber Effluent Holding Tank ($\mu\text{g/l}$) | IWTP Influent ($\mu\text{g/l}$) | Blank ($\mu\text{g/l}$) |
|--|--|--|--|-----------------------------------|---------------------------|
| Perfluorooctane Sulfonate | 39 | 0.0049 | 11 | <10 | <10 |
| 2-(N-ethylperfluorooctane sulfonamido) ethyl alcohol (PFOSA) | 10* | 0.0013* | <10 | <10 | 11 |

* Assumed to be 0.0 $\mu\text{g/l}$ since the PFOSA detected in the blank exceeded the PFOSA detected in the actual sample. Similarly, the equivalent stack emission is assumed to be 0.0000 mg/dscm.

The concentrations of the PFOS compounds that were detected are probably suspect for the following two reasons. (1) Only one sample was taken from each of the four sources. (2) The ratio of chromium to PFOS compounds in the electroplating bath is greater than 720:1 (chromium concentration is about 12.6 % and OFS concentration – of which PFOS compounds are only one type of constituent – is less than 0.0175 %). The average concentration of total chromium in the stack emissions to the scrubber from the same tests was 0.0568 mg/dscm. Therefore, the concentration of PFOS compounds should not have exceeded 0.000079 mg/dscm (0.0568/720), as opposed to the 0.0049 suggested in Table 5-7.

Based on the above, it is difficult to draw any comprehensive conclusions from the PFOS testing data except that the concentration of perfluorooctane sulfonate is much less than 0.0049 $\mu\text{g/l}$ in the exhaust gases entering the scrubber; but some PFOS does become entrained in the vapors drawn from the tank surface. No testing was conducted for PFOS after the scrubber.

5.1.5.2 Concentration of Chromium Plating Bath Constituents

Five chromium electroplating baths were sampled, two from NADEP Cherry Point, two from Tinker AFB, and one from NADEP North Island. Two of the five samples were from the baths from which stack and industrial hygiene (IH) samples were taken at NADEP Cherry Point and

Tinker AFB. Both contained WA/FS. Two of the five samples were from other non-WA/FS chromium electroplating baths at NADEP Cherry Point and Tinker AFB. The NADEP North Island sample was taken from a chromium electroplating bath containing WA/FS. No definitive conclusions can be drawn from the bath sampling data with respect to the effect of bath contents on: stack sampling, IH sampling, or product quality results. Highlights of the data are presented below.

The sampling data showed that the hexavalent chromium concentrations in each of the five baths ranged from 12.6 to 15.1 percent. (Interestingly, the hexavalent chromium analyses of the five baths *exceeded* the total chromium analyses by 20.0 to 36.6 percent. For instance, for Tank No. 155 at NADEP Cherry Point, the hexavalent chromium concentration was 12.6 percent, and the total chromium concentration was 10.5 percent. This is, of course, a physical impossibility, but this phenomenon is not unusual when analyzing chromium in the percent concentration range [1 percent equals 10,000 mg/l].)

With respect to trace metals, one of the baths sampled had consistently higher trace metal concentrations than the other four baths. (This was Tank No. 099 at NADEP Cherry Point, *not* one of the baths on which stack and IH samples were taken.) Its aluminum concentration was 1,480 mg/l (aluminum ranged from 6.2 to 35.6 mg/l in the other four baths). Its iron concentration was 345 mg/l (iron ranged from 30.4 to 233 mg/l in the other four baths). Its copper concentration was 245 mg/l (copper ranged from 4.75 to 117 mg/l in the other four baths). Its nickel concentration was 140 mg/l (nickel ranged from 1.48 to 8.64 mg/l in the other four baths). Its lead concentration was 57.7 mg/l (lead ranged from 18.0 to 49.8 mg/l in the other four baths). Its zinc concentration was 37.8 mg/l (zinc ranged from 1.78 to 15.9 mg/l in the other four baths). It is theorized that the reason that Tank 009 at NADEP Cherry Point has much higher trace components than other baths is because for a long time evaporation makeup for baths at NADEP Cherry Point was accomplished using tap water. Conceivably the tap water components would have become concentrated over a long time period.

Suspended solids concentrations in the five baths ranged from 110 to 618 mg/l. The two highest suspended solids values were for Tank 155 at NADEP Cherry Point (618 mg/l), and Tank No. 222 at Tinker AFB (344 mg/l). Both of these baths were the baths that were sampled for stack and IH emissions.

5.2 Technology Comparison

Summarizing Section 5.1.2, stack emissions data, it can be stated with great confidence that there is a vast improvement in the emissions of chromium when WA/FS is used (from 20- to 70-fold). However, the emissions performance is still not good enough that emissions will consistently meet USEPA NESHAP standards for chromium emissions from hard chromium electroplating operations without the use of other APCDs (e.g., scrubbers). Nevertheless, significant amounts of chromium that are emitted to exhaust systems when WA/FS is not in use will be saved if the use of WA/FS is implemented. Additional savings will be realized because less chromium will enter and be captured by air scrubber systems, and therefore, less chromium will require treatment and disposal as a hazardous waste.

Summarizing Section 5.1.3, IH data, it can be stated that occupational exposures to hexavalent chromium, whether or not WA/FS are used, are very low compared to the current OSHA PEL. In general most samples would even comply with the most stringent anticipated OSHA PEL. Regardless, it is also clear that occupational exposures are reduced significantly when WA/FS is used in chromium electroplating baths. Such reduction can only make for a safer working environment for electroplating shop workers.

Summarizing Section 5.1.4, material quality, based on the empirical data from NADEP North Island's use of Fumetrol® 140 for more than 5 years and the data generated by this project, it appears that Fumetrol® 140, when used in accordance with the testing in this project, has no deleterious effect on the hard chromium plating or steel substrates on which it is electroplated.

6. Cost Assessment

6.1 Cost Performance

The cost of implementing WA/FS technology is shown in Tables 6-1 and 6-3. Table 6-1 is the cost for retrofitting WA/FS at existing facilities, such as the two facilities tested for this report (NADEP Cherry Point and Tinker AFB). Table 6-3 is the costs that would be expected to implement WA/FS at new facilities. Startup costs are considered to be a one-time cost; operation and maintenance (O&M) costs are shown on an annual basis for each hard chromium electroplating bath (assuming a bath surface area of about 25 square feet [ft²], similar to the baths tested for this report). No demobilization costs are envisioned for either new or existing systems (see footnotes to Table 6-3).

The differences between the two tables reflect the assumption that an APCD will not have to be installed at a new facility in the electroplating bath exhaust system ductwork (i.e., the use of WA/FS would control emissions to a level that would, by itself, comply with air pollution control regulations). This assumption may be flawed, because the test results from this study indicate that in most instances uncontrolled emissions from baths using WA/FS did not comply with current USEPA emission standards (see Section 5.1.2.1 and 5.2). For existing facilities two alternatives are shown (see last footnote to Table 6-1): (1) WA/FS technology is used in conjunction with the existing APCD (i.e., scrubber) system, and (2) the existing scrubber is, in effect, turned off when using WA/FS technology. The second alternative assumes that emission limits can be achieved by using WA/FS alone. Again, this assumption may be flawed.

Table 6-1. Costs of Implementing and Using WA/FS Pollution Prevention Technology at Existing Facilities (per 25-ft² bath)

| Startup | | Operation & Maintenance | | Demobilization | |
|--|------------------|--------------------------------------|---------------------|-------------------------------------|------------------|
| Activity | Cost (\$) | Activity | Cost (\$/yr) | Activity | Cost (\$) |
| Labor | 0 | Labor | 0 | Removal of Equipment and Structures | N/A |
| Planning and Contracting | 0 | Monitoring | 1,300 | Site Restoration | N/A |
| Site Preparation | 0 | Analytical Services | 0 | Decontamination | N/A |
| Capital Equipment | 800* | Equipment/Facility Modifications | 0 | Demobilization of Personnel | N/A |
| Construction | 0 | Utilities | 0/(5,710)** | | |
| Permitting and Regulatory Requirements | 0/3,590** | Training to Operate Technology | 0 | | |
| | | Effluent Treatment and Disposal | 0/(2,000)** | | |
| | | Residual Waste Handling and Disposal | 0 | | |
| | | Ancillary Equipment | 0 | | |
| | | Consumables and Supplies | (1,700) | | |
| TOTALS: | | | | | |
| Startup (one-time): | 800/4,390** | O&M (annual): | (400)/ (8,100)** | Demobilization: | 0 |

N/A – not applicable

() – Indicates a negative cost; i.e., a savings

* Includes \$300 for the cost of the one-time startup addition of WA/FS to each 800-gallon bath.

** For costs shown as x/y, “x” represents costs if there are no modifications made to the existing exhaust systems or APCDs; “y” reflects costs incurred if all APCD internals are removed, and scrubber water turned off.

The costs in Table 6-1 were calculated in the following manner:

Startup Costs

- *Labor:* These are the costs that would be incurred in having to develop local process specifications for the use of WA/FS at each DOD facility. It is assumed that, realistically, no additional facility-based hires would be required for this one-time cost. Therefore the cost is assumed to be zero.
- *Planning and Contracting:* Beyond the labor noted above for developing local process specifications, there is no additional one-time planning and contracting envisioned.
- *Site Preparation:* No site preparation is required to implement the use of WA/FS.

- *Capital Equipment:* The use of WA/FS does not require any significant capital equipment. However, a one-time addition of WA/FS to each bath is required. For an 800-gallon bath (such as the baths at NADEP Cherry Point), 2 gallons of WA/FS (Fumetrol® 140) are required at about \$150 per gallon, or a total WA/FS price of \$300. In addition, to monitor the surface tension in the hard chromium bath, it will be required to purchase a deNouy Tensiometer, costing about \$2,500. (The NADEP North Island facility uses a stalagmometer to measure surface tension. The stalagmometer costs only about \$450.) Assuming that there are five baths in each shop, the cost per bath is \$500. Therefore, the total “capital equipment” cost would be \$800 per bath (\$300 + \$500).
- *Construction:* No additional construction is required to implement the use of WA/FS.
- *Permitting and Regulatory Requirements:* Existing facilities already have air emission permits based on the APCDs already in place (typically scrubbers). If the APCDs are not modified, the use of WA/FS will only enhance their performance. Hence, no additional permitting would be required. However, if it is decided that WA/FS performance is so good that the existing APCD internals can be removed (i.e., the scrubber packing), and that the scrubber water can be turned off, such modifications would require a new (or significantly modified) permit application. It is estimated that the cost of such permitting, which might require an environmental consultant, would require about 200 labor hours, at an average assumed labor cost of about \$80 per hour, or about \$16,000. If it is assumed that the average shop has five hard chromium baths that would be covered by such a permit, then the one-time per bath cost is \$3,200. It is not anticipated that startup emissions monitoring would be required as a condition of permitting.

In addition, regulatory requirements (based on decorative chromium plating regulations) would suggest that 10 tensiometer measurements would be required the first week of operation, and 5 measurements the second week, for a total of 15 measurements. Subsequent testing would be once per week (which is the current practice at NADEP North Island where WA/FS is used routinely) as long as there were no exceedences. The once per week measurements are included under O&M costs, below. It is assumed that for a 5-bath shop, one set of measurements would require two labor-hours (for reference, NADEP North Island and Tinker AFB indicate 30 minutes per bath); therefore, 15 sets would require 30 hours. At \$65 per hour (based on a rough average of NADEP Cherry Point and NADEP North Island labor rates), the total cost would be \$1,950, or \$390 per bath. This cost would not be required if the current APCD were left in place.

Therefore, total permitting and regulatory issues would cost \$3,590 (\$3,200 + \$390) per bath if the APCD internals were removed, and scrubber water flow ceased.

O&M

- *Labor:* The only labor required for the use of WA/FS (other than monitoring and training, shown below) is the time required to add WA/FS to maintain the proper surface tension. It is estimated that this is about ½ hour per week. Realistically, this would require no additional hires, having in effect, no significant cost.

- *Monitoring:* The only routine monitoring requirement is the weekly determination of surface tension in each hard chromium bath. It is expected that this procedure, using the deNouy Tensiometer, will take 2 hours each week for a shop with five baths. Realistically, it is unlikely that this procedure would require a new hire. However, if a new hire were required, at an estimated \$65 per hour, the annual cost per bath for a 50-week year would be \$1,300. Routine emissions monitoring would not be an anticipated requirement on an existing electroplating operation that was equipped with WA/FS technology.
- *Analytical Services:* The use of WA/FS should not require any additional analytical services beyond what are already required for hard chromium bath maintenance.
- *Equipment/Facility Modifications:* No modifications to electroplating shop operations and maintenance procedures will be required when using WA/FS.
- *Utilities:* If the scrubber internals were left in place there would be no change in the use of electricity to operate the exhaust fan, nor would there be any reduction in the flow of scrubber water. However, if scrubber internals are removed, fan speed cut back to maintain the same volumetric flow (but at a lower pressure drop), and scrubber water were no longer used, the cost savings would be \$5,710 per year per bath, calculated by adding items (1) and (2) below. (No costs have been assigned the work required to lower the fan speed. It is assumed that such one-time costs will balance the value of the additional life the fan will realize by running more slowly.)
 - (1) Assuming: An average ventilation rate of 7,000 dry standard cubic feet per minute (dscfm) per bath (approximate average of each bath at NADEP Cherry Point and Tinker AFB), an assumed reduction in exhaust system pressure drop of 5 inches of water (in.H₂O) (NADEP North Island currently averages a 7.5 in.H₂O pressure drop across its scrubber), 365 day per year, 24-hour per day operation (typical of NADEP Cherry Point and Tinker AFB; in fact the baths are ventilated even when there is no electroplating taking place), 60 percent fan and motor efficiency (typical for radial bladed centrifugal fans), and 8.3¢ per kilowatt-hr (kwh) (based on Federal Trade Commission 21 May 01 national average estimates) – then a savings of about 9.2 horsepower and \$5,000 per year of electrical costs would be realized per bath.
 - (2) Assuming: The cost of water is \$3 per thousand gallons (based on an approximate average of NADEP Cherry Point and NADEP North Island costs), the scrubber make up is 2 gallons per minute (gpm) (based on NADEP Cherry Point data), the scrubber services all five hard chromium baths, and the scrubber operates 365 days per year, 24 hours per day – then a savings of \$630 per year would be realized per bath. In addition, the scrubber water recirculation pumps, recirculation sump heaters, and pipe tracing power would no longer be needed, saving the cost of electricity and maintenance for these items. These savings are estimated to be about \$80 per year per bath based on NADEP Cherry Point records.
- *Training:* Assume about three labor-hours per year for each facility (i.e., 1 hour per shift with 3 shifts) to acquaint operating labor with the use and addition of WA/FS.

Realistically, this would require no additional hires, having in effect, no cost, especially on a per-bath basis.

- *Effluent Treatment and Disposal:* NADEP Cherry Point estimates that it costs about \$15,800 annually to treat the scrubber blowdown at their industrial waste treatment facility. This cost would be avoided if the scrubber could be taken out of service. On a per-bath basis this savings would be about \$3,200 per year. NADEP North Island estimates that only about 350 gallons per day are blown down from the scrubbers and treated daily. At an estimated treatment cost of \$6.55 per thousand gallons, this equates to only about \$170 per bath per year. Based on these two estimates (i.e., \$3,200 and \$170) a value of \$2,000 per bath per year is assumed.
- *Residual Waste Handling and Disposal:* Hazardous waste sludges are created when the scrubber water blowdown is treated at the industrial waste treatment facility. The costs of disposing of these sludges probably exceed \$400 per ton. However, for NADEP Cherry Point, that cost is already included in the cost of effluent treatment and disposal, as discussed above. This is assumed to be the case for other facilities as well.
- *Ancillary Equipment:* No ancillary equipment is required to implement the use of WA/FS (other than the tensiometer discussed above).
- *Consumables and Supplies:* The use of WA/FS minimizes the loss of chromic acid to the exhaust system (i.e., to the scrubber) from the hard chromium baths. Based on sampling data (see Table 6-2), between 120 and 460 pounds per year of chromic acid are saved per year per bath when using WA/FS, at a cost of \$7 per pound. (For reference, NADEP Cherry Point pays \$7.00 per pound of chromic acid. The Chemical Marketing Reporter indicates that chromic acid in 50-pound bags is \$17.50 per pound. NADEP North Island claims that they pay \$91 per 50-lb.can, or \$1.82 per pound.) This amounts to an average saving of over \$2,000 per year per bath (assuming that the baths are in service 50 percent of the time).

However, it is necessary to maintain the appropriate surface tension in the bath, so as to maintain the chromic acid savings. It is estimated that an 800-gallon bath should require about 2 gallons of WA/FS annually to maintain the proper surface tension. At \$150 per gallon, the annual cost will be \$300. Therefore, the net savings on consumables and supplies is estimated to be \$1,700 (\$2,000 minus \$300).

| Table 6-2. Analysis of Emissions Data and Projected Cost Savings From Use of Fume Suppressant | | | | | |
|--|--|--|--|---|--|
| NADEP Cherry Point Stack Samples | | | | | |
| Set Sampling Date | Average Air Flow (dscf/min)/ (dscm/min) | Tot. Chromium Concen. (mg/dscm) | Emitted Mass of Chromium w/o WA/FS (mg/min) | Emitted Mass of Chromium with WA/FS (mg/min) | Amount of Chromic Acid Saved (lb/yr) & Cost Savings (\$/yr) |
| 7/11/00 | 4,890/138 | 3.83 | 530 | | |
| 7/12/00 | 4,890/138 | 2.18 | 302 | | |
| 9/21/00 FS* | 6,760/191 | 0.0362 | | 6.93 | |
| 11/15/00 | 5,980/169 | 1.36 | 231 | | |
| 11/16/00 FS | 6,840/194 | 0.0527 | | 10.21 | |
| 12/13/00 FS | 6,240/177 | 0.0242 | | 4.28 | |
| 3/27/01 FS | 7,810/221 | 0.0415 | | 9.18 | |
| 4/17/01 FS | 7,380/209 | 0.0197 | | 4.12 | |
| Average Chromium Emission: | | | 354 | 6.94 | 456 |
| Cost Savings per year @ \$7/lb and 50% bath use: | | | | | \$3,194 |
| Tinker AFB Stack Samples | | | | | |
| 9/12/00 | 7,400/210 | 0.474 | 99 | | |
| 10/11/00 FS | 7,740/219 | 0.0108 | | 2.37 | |
| 11/8/00 FS | 7,480/212 | 0.0061 | | 1.30 | |
| 12/6/00 FS | 7,280/206 | 0.0193 | | 3.98 | |
| 7/31/01 FS | 6,550/185 | 0.0568 | | 10.54 | |
| 8/1/01 FS | 6,520/185 | 0.0292 | | 5.39 | |
| Average Chromium Emission: | | | 99 | 4.71 | 124 |
| Cost Savings per year @ \$7/lb and 50% bath use: | | | | | \$867 |

Note: * FS signifies that fume suppressant was used for this series of tests.

Demobilization Costs

No significant costs are associated with WA/FS use when demobilizing an electroplating line (Table 6-3). No equipment must be removed beyond what was already in place prior to the use of WA/FS.

Table 6-3. Costs of Implementing and Using WA/FS Pollution Prevention Technology at New Facilities (per 25-ft² bath)

| Startup | | Operation & Maintenance | | Demobilization | |
|--|-------------|--------------------------------------|--------------|-------------------------------------|-----------|
| Activity | Cost (\$) | Activity | Cost (\$/yr) | Activity | Cost (\$) |
| Labor | 0 | Labor | 0 | Removal of Equipment and Structures | N/A |
| Planning and Contracting | 0 | Monitoring | 1,300 | Site Restoration | N/A |
| Site Preparation | 0 | Analytical Services | 0 | Decontamination | N/A |
| Capital Equipment | 800* | Equipment/Facility Modifications | 0 | Demobilization of Personnel | N/A |
| Construction | (46,000)*** | Utilities | (5,710) | | |
| Permitting and Regulatory Requirements | 0 | Training to Operate Technology | 0 | | |
| | | Effluent Treatment and Disposal | (2,000) | | |
| | | Residual Waste Handling and Disposal | 0 | | |
| | | Ancillary Equipment | 0 | | |
| | | Consumables and Supplies | (1,700) | | |
| | | | | | |
| TOTALS: | | | | | |
| Startup (one-time): | (45,200) | O&M (annual): | (8,100) | Demobilization: | 0** |

Note: N/A – not applicable

* Includes \$300 for the cost of the one-time startup addition of WA/FS to each 800-gallon bath.

** In fact, there is a distinct cost savings for demobilizing new hard chromium plating operations that use WA/FS, and therefore, do not use scrubbers; i.e., there are no scrubbers and associated equipment to demobilize at the end of the useful life of the hard chromium plating operation. However, these savings are not included in this analysis.

*** Construction cost savings reflects the fact that the cost of capital equipment (a scrubber and associated equipment) plus installation is not required.

The costs in Table 6-3 were calculated in the following manner:

Startup Costs

All elements of startup costs for new hard chromium installations are identical to those shown in Table 6-1 for existing systems where the scrubber has been taken out of service, except as follows:

- *Construction:* There are significant one-time cost savings during construction because it is assumed that a scrubber does not have to be installed, and a smaller fan and motor can be used (since the pressure drop associated with a scrubber no longer exists). Note that this assumption may be flawed, as explained in the Section 6.1. NADEP Cherry Point estimated that the installed cost of the scrubber system (not including fan and ductwork, which will be required for any ventilation system) for their five hard chromium electroplating baths was \$175,000 when installed. For NADEP North Island the scrubber system capital cost was estimated at \$500,000, including fan and ductwork, and including a second scrubber system for non-chromate bath fumes (e.g., from hot alkaline cleaners). It is therefore expected that the North Island costs are in line with the NADEP Cherry Point costs, or about \$200,000 for the relevant system parts. Hence, the average cost of a scrubber system for emissions from hard chromium electroplating would be about \$200,000 for an installed scrubber and high pressure drop fan. Since the systems were installed at least 5 years ago, it is reasonable to assume that current costs would be about \$230,000 (3.2 percent escalation for 5 years). Therefore, the startup cost savings per bath is estimated to be \$46,000.
- *Permitting and Regulatory Requirements:* It is estimated that a new system installed with or without the use of WA/FS technology would still require approximately the same level of effort to obtain permitting. Hence, there is no additional cost (or savings) associated with permitting a WA/FS-equipped system, as opposed to a scrubber-equipped system.

O&M

The operating and maintenance costs associated with a new hard chromium electroplating bath system equipped with WA/FS technology are essentially the same as for retrofitting an existing system. One might argue that there would be additional electricity cost savings on a new system, since the fan and motor on a new system could be designed to be the right size rather than slowing down the speed of an existing fan. However, this degree of detailed analysis is difficult to perform. Therefore, it is assumed, conservatively, that the electricity savings is \$5,710 per year, as it was when retrofitting an existing system.

Demobilization Costs

Demobilization costs for new systems are assumed to be zero. In fact, there is a distinct cost *savings* for demobilizing new hard chromium plating operations that use WA/FS instead of scrubbers (i.e., there are no scrubbers and associated equipment to demobilize at the end of the useful life of the hard chromium plating operation). Conservatively, however, these savings are not included in this analysis.

6.2 Cost Comparisons to Conventional and other Technologies

Table 6-4 summarizes the relative costs and savings shown in Tables 6-1 and 6-3 for the three different scenarios in which WA/FS technology is used. Tables 6-1 and 6-3 both compare the

use of WA/FS technology to the conventional technology of using a wet scrubber (or similar APCD) in the exhaust ductwork. Table 6-1 evaluates two scenarios for *existing* hard chromium electroplating baths, and Table 6-3 evaluates the use of WA/FS in *new* electroplating systems.

Table 6-1 gives two cost alternatives relating to the use of WA/FS on existing hard chromium electroplating baths. The first alternative is for using WA/FS in addition to the existing scrubber. Even though this approach might not appear to be economical, in fact it is economical because the WA/FS prevents the loss of chromic acid plating solution. Specifically (see Table 6-1 Totals), there are one-time startup costs of \$800, and annual O&M *savings* of \$400. If it is assumed that the bath/scrubber system have a 10-year effective life cycle, and that the Real Discount Rate used by federal government agencies is 3.2 percent per year (OMB Circular A-94), then the effective annual equivalent cost of the \$800 startup cost is \$95. Therefore, the effective annual *saving*, per bath, of this alternative is about \$300 per year (\$400 minus \$95). This savings represents a payback of the \$800 startup costs of fewer than three years.

The second alternative presented in Table 6-1, in which the scrubber system is, in effect, shut off, will have an effective annual *savings*, per bath, of about \$7,600. (The 4,390 startup costs have an annualized value of \$520, subtracted from the annual O&M savings of \$8,100.) This savings represents a payback period of the \$4,390 startup costs of less than seven months.

Table 6-3 shows that for a new installation one-time startup costs are about \$45,200 *less* than for a conventional system with a scrubber. In addition, about \$8,100 in O&M savings occurs every year. The effective annual *savings* are therefore, about \$13,450 per bath. (The annualized value of the \$45,200 savings is about \$5,350, plus the \$8,100 annual O&M savings.) Since the startup costs are less than a conventional scrubber system would be, “payback period” is not relevant.

Again, it should be noted that the savings attributable to shutting off existing scrubbers, or not installing scrubbers on new hard chromium electroplating operations, may not be available. This is because emissions from hard chromium electroplating baths using WA/FS, as measured in this study, while improved by 20- to 70-fold as compared to baths without WA/FS, still do not routinely comply with USEPA hard chromium quantitative emission standards.

**Table 6-4. Summary of Annual Savings When Using WA/FS
(Dollars per hard chromium plating bath)***

| | Existing Hard Chromium Line | | New Hard Chromium Line*** |
|---|------------------------------------|-------------------------------------|----------------------------------|
| | WA/FS plus scrubber | WA/FS with scrubber disabled | |
| Startup Costs | 800 | 4,390 | (45,200) |
| Annualized Startup Costs/Savings** | 95 | 520 | (5,350) |
| Annual O&M Costs/Savings | (400) | (8,100) | (8,100) |
| Total Annual Cost/Savings | (300) | (7,600) | (13,450) |
| Payback Period (years) | 2.7 | 0.6 | N/A |

Note:

* Savings are in parentheses ().

** Annualized costs/savings are calculated based on 10 years equipment life for capital equipment, and a Real Discount Rate of 3.2 percent per year.

*** Assumes that an APCD (i.e., a Scrubber System) will not be required.

7. Regulatory Issues

Currently, DOD hard chromium electroplating baths have air emissions permits for discharging to the atmosphere (see Section 1.3 for regulatory standards). Using WA/FS will not, under current and foreseeable future USEPA regulations, eliminate the need for these permits. Even though the use of WA/FS will undoubtedly lower the amount of chromium exhausted to APCDs, it will probably not be any less time consuming to obtain new or renewal permits from permitting agencies. However, DOD should persist in efforts to convince USEPA to allow the use of WA/FS *instead of* APCDs, as USEPA has done for *decorative* chromium electroplaters. If successful in these efforts there would be potentially great savings in being able to “turn off” existing APCDs, or in not having to install APCDs on any new hard chromium electroplating baths. With respect to this project, USEPA’s Risk Management Research Laboratory (RMRL), in Cincinnati, Ohio, (Mr. David Ferguson) has consulted with the Naval Facilities Engineering Service Center (NFESC) Project Coordinator (Ms. Kathleen Paulson). The project Demonstration Plan was reviewed and coordinated with RMRL. It is hoped that the results of this study will be used by USEPA to support a regulatory change such that WA/FS may be used in hard chromium electroplating as an alternative to APCDs.

It is recognized that most of the emissions data developed in this study while using only WA/FS technology would not meet the current USEPA criterion for chromium emissions. However, the improvement in chromium plating bath emissions is so great with WA/FS, that it is conceivable that minor modifications in operating practices might allow the achievement of USEPA’s criterion. Specifically, providing an additional inch or two of freeboard might assist in keeping mist from exhaust system intakes. Likewise, mixing baths mechanically (e.g., with recirculating pumps or mixers) instead of with air would eliminate aeration as a source of mist. (Mechanical mixing is already practiced at NADEP North Island.)

With respect to OSHA compliance relative to in-plant emissions of hexavalent chromium, this study has shown that WA/FS lowers the amount of hexavalent chromium available for respiration by workers. This might allow hard chromium electroplating baths to operate with less exhaust volume, and still comply with OSHA regulations (current or proposed). This would be a benefit for new hard chromium installations, but probably result in no practical savings for existing installations. Although, for existing installations (or new installations whose ventilation systems are designed to current ventilation standards), the use of WA/FS should lower workman compensation liability with respect to hexavalent chromium respiratory illness claims.

With respect to the use of WA/FS, USEPA has issued a proposed rule (65 FR 62319, 18 Oct 00), *Perfluorooctyl Sulfonates; Proposed Significant New Use* that could affect the use of the WA/FS tested for this project (Fumetrol® 140). The proposed rule would require that manufacturers of PFOS compounds notify USEPA before commencing manufacture of these substances. USEPA is concerned that these compounds, which appear to be the primary active ingredient in Fumetrol® 140, may be “hazardous to human health and the environment.” However, the regulation appears to target the primary use of PFOS, which is the treatment of fabrics and paper to provide soil and water resistance. This proposed rule has no immediate effect on the use of WA/FS. However, it is conceivable the proposed rule might lead to banning or reducing the use of such compounds for certain uses. The recommended dosage of Fumetrol® 140 for hard

chromium electroplating baths is only 0.25 percent. Therefore, it is unlikely that such low concentration use would ever be regulated for hard chromium operations, especially since its function is to significantly reduce the environmental and occupational exposure to a known carcinogen, hexavalent chromium.

8. Technology Implementation

8.1 DOD Need

Sections 5 and 6 of this report show that the use of WA/FS (specifically Fumetrol® 140) is likely to cause atmospheric emissions of hexavalent chromium from hard chromium electroplating baths to be reduced by one to two orders of magnitude. This emission reduction will have obvious health benefits to the employees in the electroplating shops. In addition, using WA/FS has the potential, in new electroplating installations, to eliminate the need for APCDs, and their inherent capital and operating costs. For existing shops, the use of WA/FS may allow existing APCDs to be taken out of service, eliminating current APCD operating costs. For all shops, there will be an immediate savings in the cost of chromic acid replacement, because losses of chromic acid mist to the atmosphere will be minimized. Additionally, Section 5.1.4 shows that the use of Fumetrol® 140 does not appear to have any measurable negative effect on the quality of hard chromium electroplated parts.

It would appear that there are many health and financial advantages for DOD to use WA/FS in hard chromium electroplating baths, and few, if any, downside risks.

8.2 Transition

Each DOD facility would need to implement the use of WA/FS based on the protocols for the particular DOD branch (i.e., Army, Navy, Air Force, Marines, Coast Guard). For NAVAIR, for example, approval for implementation of Fumetrol® 140 is planned to be accomplished by issuing a formal Navy message that details engineering concurrence from NAVAIR Materials, Structures and Subsystems Divisions based on data provided by this project. This concurrence is planned to extend to the support of NAVAIR OEMs in the construction and repair of NAVAIR aircraft and supporting equipment. Each facility will need to change their local process specifications to accommodate the quality assurance/quality control (QA/QC) of the bath concentration and surface tension monitoring.

8.3 Toxicology

PFOS technical information included in the MSDS, the manufacturer's technical data sheets and the laboratory results were shared with the NEHC and the Navy Toxicology Detachment, Dayton, Ohio. Both organizations conducted independent investigations on the affects of PFOS and determined that while they cannot establish that PFOS is safe, the risk of hexavalent chromium exposure outweighs the risks from the small amount of PFOS used in the bath. See Appendix I for the reports.

9. Lessons Learned

9.1 Bath Maintenance Effects Surface Tension

It was the original intention of this study to do one baseline test (i.e., without WA/FS) at each of the facilities tested (NADEP Cherry Point and Tinker AFB). Subsequent testing at both facilities was expected to be only with WA/FS in the baths. At NADEP Cherry Point, however, the facility was not able to reduce the surface tension to below the desired 30 dynes per centimeter range in the bath being tested (Tank No. 155). After the baseline test, 33 dynes/cm appeared to be as low as the facility could achieve by adding WA/FS. Consequently, the bath was changed out, and replaced with fresh components. Another baseline test was run (on 15 Nov 00), and then WA/FS was added for subsequent testing. On the fresh bath surface tensions between 23 and 27 dynes/cm were achieved.

At the time the original Tank No. 155 was put into service, and for several years of use, tap water was used to make up for evaporation and dragout. Therefore, it was concluded that the buildup of dissolved salts from the tap water (e.g., magnesium, calcium, trace metals, anions) reduced the ability of the WA/FS to effectively lower the surface tension. In support of this conclusion, Section 5.1.5.2 of this report presents constituency data for Tank No. 099 at NADEP Cherry Point. Tank No. 099 is another chromium plating bath that did not contain WA/FS, but was sampled to compare the constituency of various chromium electroplating baths. Tank No. 099, which probably has the same history as the original bath contents in Tank No. 155, has a significantly higher concentration of trace metals than the other chromium electroplating baths that were analyzed.

This experience suggests that surface tension reduction may not be achievable in chromium electroplating baths with excessive amounts of contamination, or unless dragout and evaporation are replaced with distilled or deionized water, as they are at Tinker AFB and NADEP North Island. (NADEP Cherry Point also recently converted to deionized water.)

9.2 Other Observations

The question often raised about the emission of mist from electroplating baths is whether the misting is due primarily to electrical activity at the anodes and cathodes (i.e., the production of hydrogen and oxygen gases), or from mechanical aeration of the baths to facilitate mixing. The answer became apparent inadvertently during the first day of baseline testing (i.e., testing without WA/FS) at NADEP Cherry Point (11 July 00). During the first of the three tests on that day there was no electroplating load in the bath. However, the bath was aerated. The emissions from that test were 0.0454 milligrams per dry standard cubic meter (mg/dscm) of hexavalent chromium. The two following tests, under the same conditions, except with loads in the bath, were 6.32 and 0.737 mg/dscm respectively, at least more than one order of magnitude higher than with aeration alone. These data would suggest that emissions from electrolytic activity are far more significant than from mechanical aeration.

Finally, in a few cases very high values and non detect values in four side-by-side samples. In hindsight taking more industrial hygiene baseline samples would have been beneficial in sorting through the non- detect and outlier values.

10. References

1. *Chromium Emissions from Chromium Electroplating and Chromic Acid Anodizing Operations-Background Information for Proposed Standards* (EPA 453/R-93-030a), Volume 1, July 1993.
2. David Ferguson, Matthew Zellen, Dawn Brennan, Janette Lutz. *Use of Fume Suppressants in Hard Chromium Baths-Quality Testing*. Plating and Surface Finishing. Feb 2000, Vol 87, No. 2, pp 67-72.
3. David Ferguson, Briana Sprague, Dawn Brennan, Janette Lutz. *Use of Fume Suppressants in Hard Chromium Baths-Emission Testing*. Plating and Surface Finishing. Jan 2000, Vol 87, No.1, pp 72-74
4. *Circular No. A-94, Revised (Transmittal Memo No. 64), Guidelines and Discount Rates for Benefit-Cost Analysis of Federal Programs*, Memorandum for Heads of Executive Departments and Establishments, <http://www.whitehouse.gov/omb/circulars/a094/a094.html>, October 29, 1992.
5. *Determination of Chromium Emissions from Decorative and Hard Chrome Electroplating and Anodizing Operations*, USEPA Method 306. <http://www.epa.gov/ttn/emc/promgate/m-306.pdf>
6. *Hexavalent Chromium in Workplace Atmospheres*. OSHA Method 215, Occupational Safety and Health Administration. <http://www.osha-slc.gov/dts/sltc/methods/inorganic/id215/id215.html>. June 1998
7. *The Navy Industrial Hygiene Field Operations Manual*. Naval Environmental Health Center. <http://www-nehc.med.navy.mil/ih/ihfom99.htm>. 1999 John R Mulhausen, Joseph Damiano.
8. *Strategy for Assessing and Managing Occupational Exposures*. American Industrial Hygiene Association. 1998.
9. *Chromium Plating (Electrodeposited)*. Federal Specification QQ-C-320B(4). http://astimage.daps.dla.mil/quicksearch/basic_profile.cfm?ident_number=50938. Naval Air Systems Command. 10 April 1987

APPENDIX A

POINTS OF CONTACT

Table A-1. Point of Contact

| Name | Organization/Code | Phone Number | E-mail Address | Fax Number | Street Address | Role in Project |
|---|---|------------------------------|--|-------------------|---|---|
| Principal Investigators | | | | | | |
| Kathleen (Kappy) Paulson | NFESC/NAVOSH Engineering (ESC425) | 805-982-4984 DSN 551-4984 | paulsonkm@nfesc.navy.mil | 805-982-1409 | 1100 23 rd Street, Port Hueneme, CA 93043 | Project Coordinator |
| Craig Matzdorf | NAVAIR/ Code 4.3.4.1 Aerospace Materials Division | 301-342-9372 | matzdorf@navair.navy.mil | 301-342-7566 | 48066 Shaw Rd Patuxent River, MD 20670 | Materials Evaluation |
| T. David (Dave) Ferguson | EPA Risk Management Research Lab | 513-569-7518 | ferguson.david@epa.gov | 513-569-7471 | 26 W. M.L. King Dr. Cincinnati, OH 45268 | EPA Consultant on field testing |
| Roger C Wilmoth | NRMRL, Multimedia Technology Branch Chief | 513-569-7509 | wilmoth.roger@epa.gov | 513-569-7471 | 26 W. M.L. King Dr. Cincinnati, OH 45268 | |
| Air Logistics Center - Tinker AFB, Oklahoma City, OK | | | | | | |
| Glen Graham | ALC-OKC | 405-736-2018 DSN 336-2018 | Glen.Graham@Tinker.af.mil | 405-736-2501 | Attn: Glen H. Graham OC-ALC / LPPEE 3001 STAFF DRIVE POST 2B93 TINKER AFB, OK 73145 - 3034 | Materials Engineer Tinker AFB Contact |
| Tom Morris | ALC-OKC | 405-736-2503 | tom.morris@Tinker.af.mil | | same as G. Graham | Facilities Manager |
| Ernest Barlor | ALC-OKC | 405-736-5280 DSN 336-5280 | earnest.barlor@Tinker.af.mil note: name is <i>incorrectly</i> spelled in e-mail address | | Attn: Ernest Barlor OC-ALC / LPPCH 3001 STAFF DRIVE POST 2B93 TINKER AFB, OK 73145 - 3034 | Solution Maintenance Sub unit |
| Jerry Jones | ALC-OKC | 405-736-3489 405-736-2135 | jerry.jones@Tinker.af.mil chris.mance@Tinker.af.mil | | | Plating Chemistry Laboratory |
| Don Riddle | | 405-734-7844 | don.riddle@Tinker.af.mil | | | Safety Manager |
| NADEP Cherry Point, NC | | | | | | |
| Jesse Garman | NADEP Cherry Point, NC | 252-464-9886 | garmanjs@navair.navy.mil | 255-464-8108 | Code 4.3.4.4 PSC Box 8021 NADEP Cherry Point, NC 28533-0021 | Materials Chemist NADEP Cherry Point POC |

| Name | Organization/Code | Phone Number | E-mail Address | Fax Number | Street Address | Role in Project |
|-----------------------------------|---------------------------|------------------------------|--|------------------|---|---|
| Robert (Yogi) Kessler | NADEP CP | 252-464-9888 | kestlerre@navair.navy.mil | 255-464-8108 | PSC Box 8021 NADEP Cherry Point, NC 28533-0021 | NADEP Cherry Point Back-up POC |
| Beth Holland | NADEP Cherry Point | 252-464-7037 | hollandem@navair.navy.mil | | Command Support Office Code 6.8 | NADEP Cherry Point, Safety & Occ Health Department |
| Ken Lewis | NADEP Cherry Point | 252-464-8114 | Lewislb@navair.navy.mil | | Production Department Code 6.2.936 | NADEP Cherry Point Plating Facility Supervisor |
| NADEP North Island, San Diego, CA | | | | | | |
| Gary Kuhlman | NADEP North Island, CA | 619-545-9733 | Kulhmangr@navair.navy.mil | | Code 43400 Building 464-1 San Diego, Ca 92135 | Materials Lab POC |
| Ernie Shiwanov | NADEPNI/43420 | 619-545-7834 | Shiwanove@navair.navy.mil | | | Chem/Materials Engineer |
| Ed Duffey | NADEPNI/43410 | 619-545-9760 | Duffeyr@navair.navy.mil | | Code 4341 | Metallurgist/Engineer |
| Cathy Jennings | NMCSD/PCB | 619-545-108? | | | | Industrial Hygienist |
| Don Chateau | NADEP/61614 | 619-545-588 | Chateaudt@navair.navy.mil | | Code 61600 Bldg 90-2 | NADEPNI Facilities |
| Michele Merien | NADEP/09200 | 619-545-2234 | | | | NADEPNI |
| Mike Stagg | | 619-545-3342 | | | | Air Pollution |
| Lary Lai | NADEP/08213 | 619-545-9200 | | | | NADEP-NI Environmental |
| Joe Everett | NADEP/ | 619-545-4251 DSN 735-4251 | everett_j@a1.nadeppni.navy.mil | 619-545- 5479 | PO Box 357058 San Diego CA 92135- 7058 | Processing Prod Center Electroplater Supervisor Pager 619-979-4058 |
| Larry Lausin | NADEP/61226 | 619-545-3053 DSN 735-3053 | lausinl@navair.navy.mil | 619-545- 5399 | PO Box 357058 San Diego CA 92135- 7058 | Industrial Equipment Mgr. Equipment Management Office Building 90-2 |
| Horace Hill | NADEP/ | 619-545-3694 DSN 735-3693 | hillh@navair.navy.mil | 619-545- 3695 | " | OSH Specialist Pager 619-979-4735 |
| Contractors | | | | | | |
| Stephen M. (Steve) Schwartz | Versar, Inc | 703/642-6787 | schwaste@versar.com | 703/642-6954 | 6850 Versar Center Springfield, VA 22151- 4196 | Contractor directing IH & Environmental field testing |
| Jennifer Brown | Versar Inc | 703/642-6809 | brownjen@versar.com | 703/642-6891 | " | CIH |
| Bryan Arnold | Versar Inc. | 630/268-8555 | arnolbry@versar.com | 630/268-0555 | 200 West 22nd Street, Suite 250 Lombard, IL 60148 | CIH |

| Name | Organization/Code | Phone Number | E-mail Address | Fax Number | Street Address | Role in Project |
|----------------|--------------------------------|-----------------------|--|-------------------|---|--------------------------------------|
| Laboratories | | | | | | |
| George Lindsay | NEPMU 2, Norfolk | 757/444- 7671x3038 | lindsavg@nepmu2.med.navy.mil | 757/444-1556 | NEPMU 2/CHIL 1887 Powatan Street Norfolk, VA 23511-3394 | Lab Director |
| Chuck Kubrock | NEPMU5, San Diego | 619/556-1334 | | 619/556-1492 | NEPMU 5/CHIL Naval Station, Box 368143 3235 Albacore Alley San Diego, CA 92136-5199 | Lab Director |
| Dr Kate Luk | Research Triangle Institute | 919/541-6569 | kkl@rti.org | 919/541-7215 | 3040 Cornwallis Rd., PO Box 12194, Research Triangle Park, NC 27709-2194 | Analytical Laboratory Coordinator |

APPENDIX B

DATA ARCHIVING AND DEMONSTRATION PLAN

For a minimum of 10 years after completion of the project, all environmental and occupational safety and health test results will be stored at Naval Facilities Engineering Service Center, Port Hueneme, California. Additionally, the approved Demonstration Plan (dated 15 October 2000) will be stored at the same location. For a minimum of 10 years after completion of the project, all material quality test results will be stored at Naval Aviation Systems command, Becker Laboratory, Patuxent River, Maryland. Project records will be kept in Mr. Craig Matzdorf's files at NAVAIR Laboratory. Testing records will be filed in the Inorganic Coatings Laboratory with Mr. Matzdorf. Stored materials will include all magnetic and hard copies of data, calibrations, equipment maintenance records calculations, records of original observations, final test results and miscellaneous quality records directly associated with sample analysis. An e-mail file of major correspondence will also be preserved with the magnetic material.

In the case of personnel changes, NFESC has a SERDEP/ESTCP Program Manager. Project materials will be turned over to the responsible individuals. At NAVAIR, project records will be turned over to the Materials Protection Branch Head. Test records will remain a part of the Inorganic Coatings Laboratory per NAVAIR Materials Division's, Quality System.

APPENDIX C

PHOTOGRAPHS

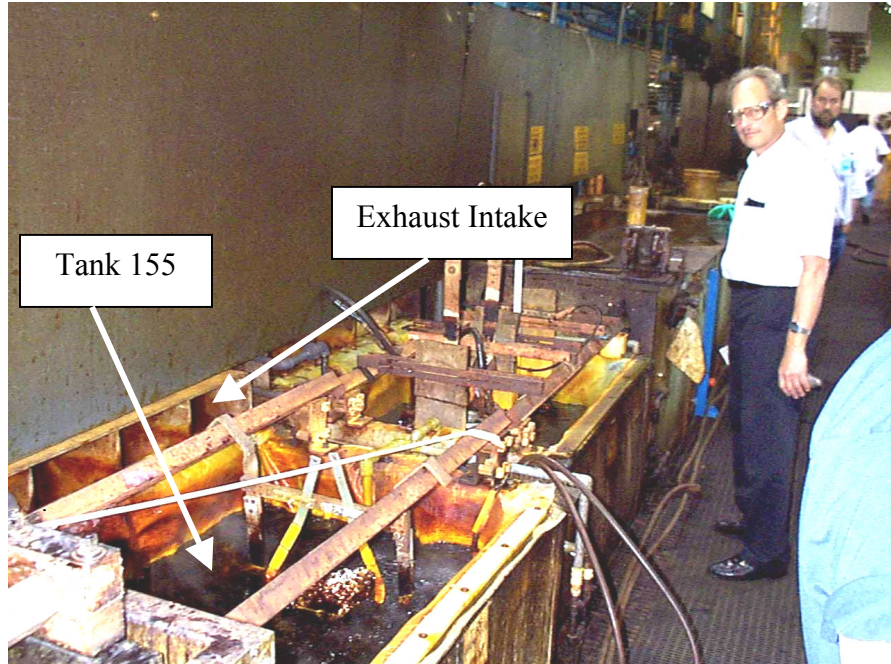


Figure C-1. NADEP CHERRY POINT, TANK NO. 155

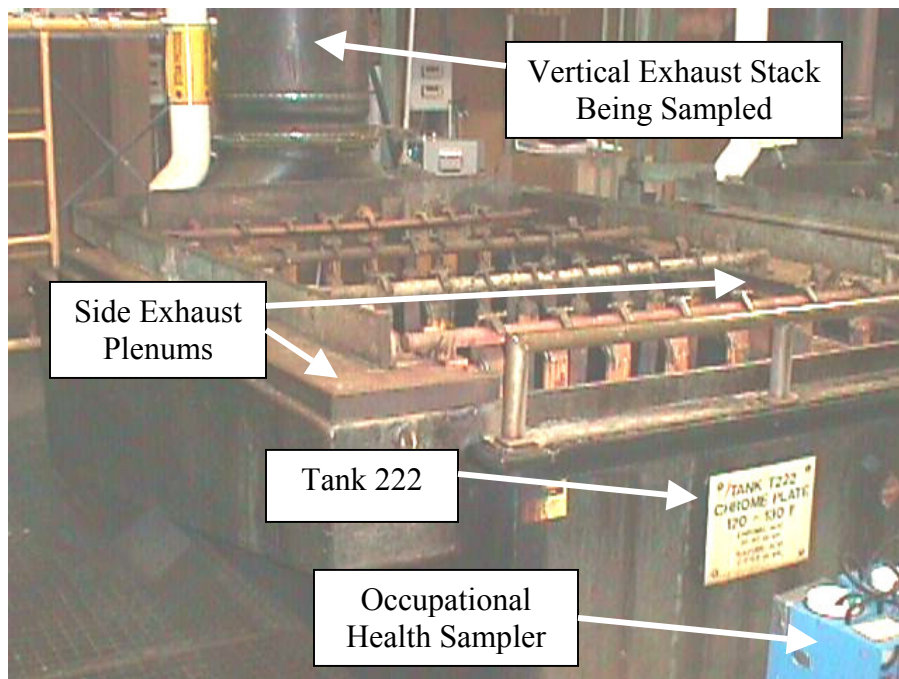
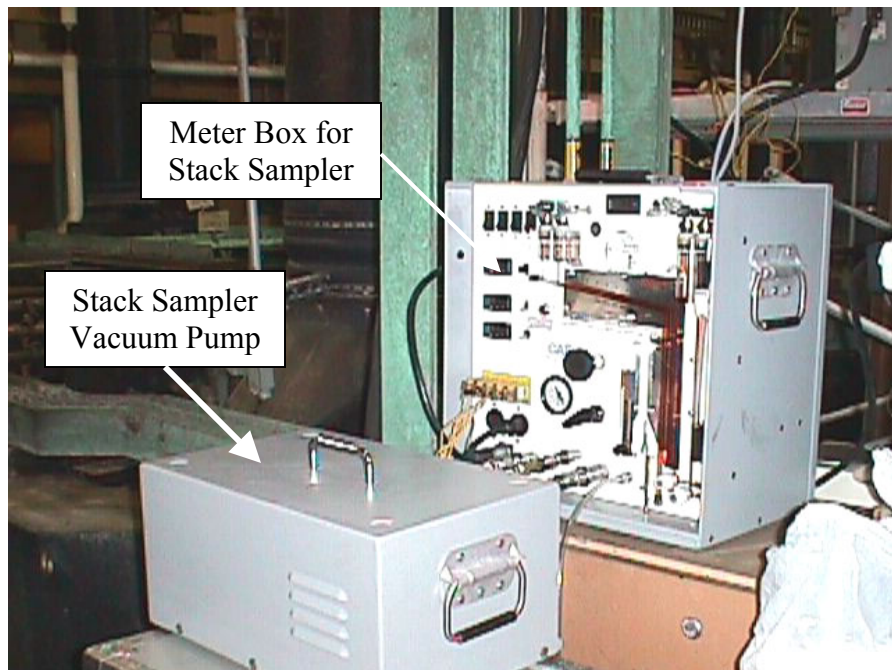
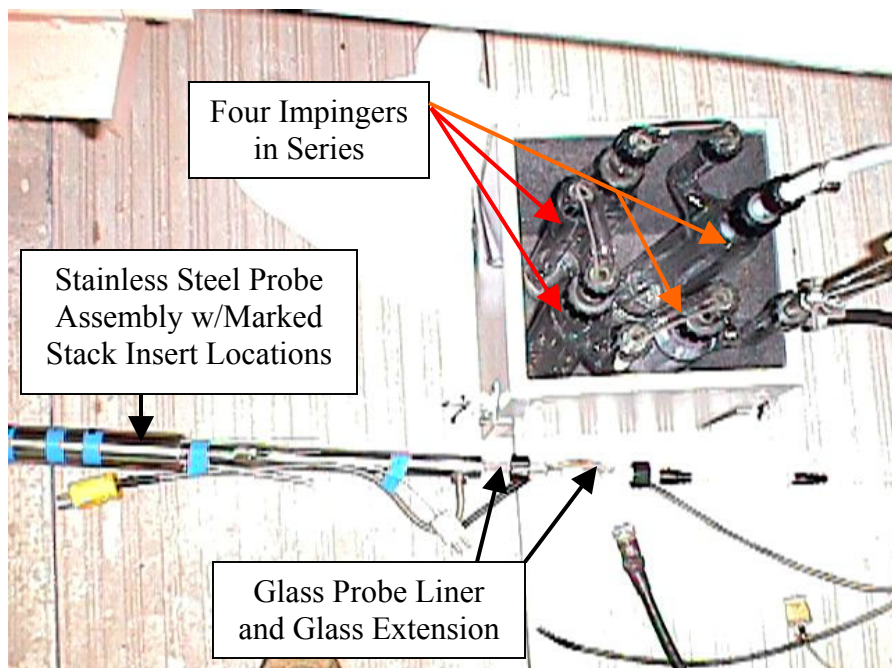


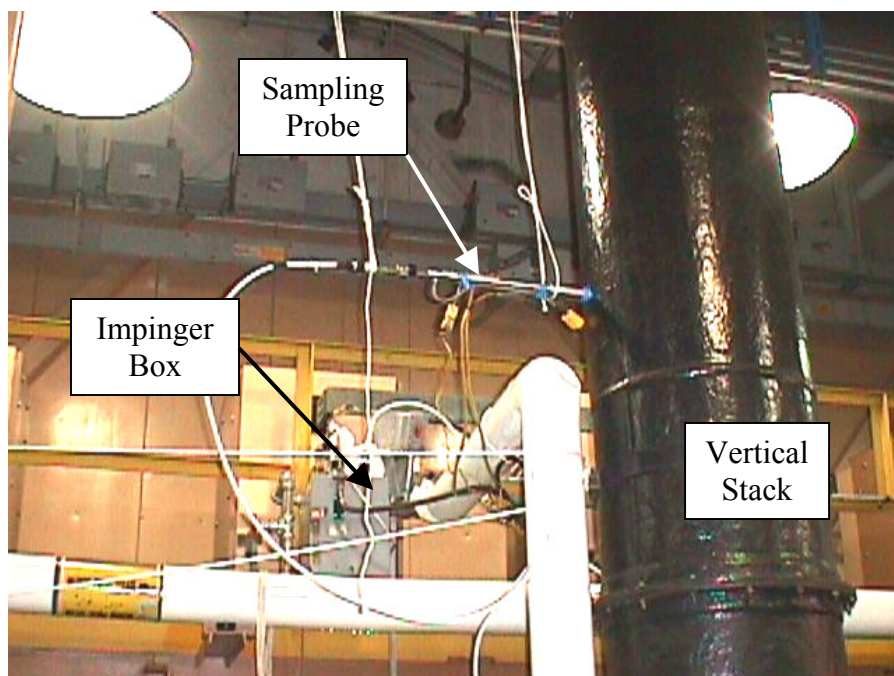
Figure 2. TINKER AFB, TANK NO. 222



**Figure 3. STACK SAMPLER METER BOX AND PUMP
(at TINKER AFB)**



**Figure 4. IMPINGER CASE FOR STACK SAMPLER
AND PROBE ASSEMBLY**



**Figure 5. STACK SAMPLING ASSEMBLY
(at TINKER AFB)**



**Figure 6. OCCUPATIONAL HEALTH SAMPLING EQUIPMENT
(at TINKER AFB)**

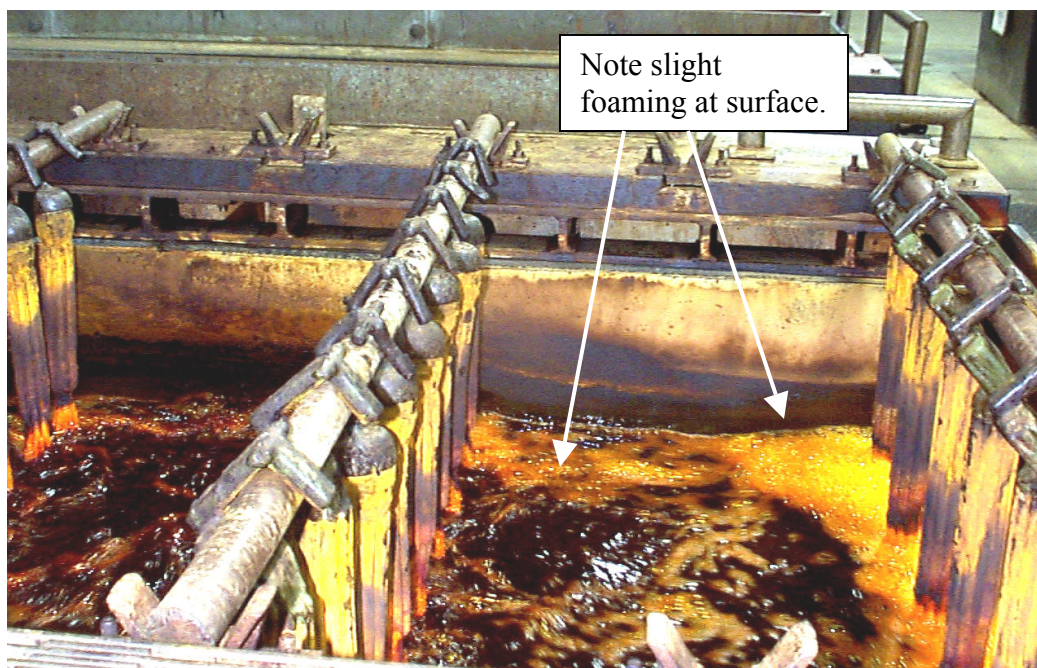


Figure 7. TINKER AFB, TANK NO. 222 WITH FUMETROL® 140



Figure 8. TINKER AFB, TANK NO. 222 WITHOUT FUMETROL® 140



Figure 9. NADEP NORTH ISLAND FUME SCRUBBERS

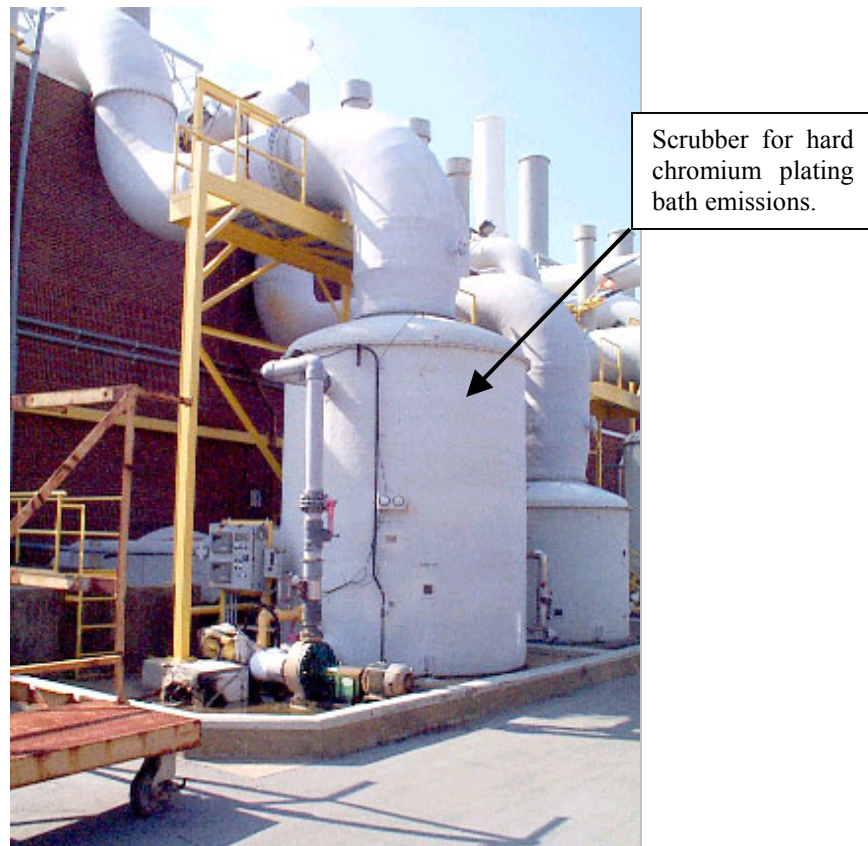


Figure 10. NADEP CHERRY POINT FUME SCRUBBERS

APPENDIX D

TESTING AND SCHEDULING TABLES

Table D-1 - Test Plan for Materials, Environmental, and Occupational Health Testing

| Parameter | Sample Type | Method Number | Method Title | Method Type | Number of Samples | Controls |
|---|-----------------------------------|-----------------------|--|---|--|-----------------------------|
| Test events per facility, each day, planned at Tinker AFB and NADEP Cherry Point | | | | | | |
| Stack Gas – Hexavalent Chromium | Time weighted average | EPA 306 | <i>Determination of Chromium Emissions from Decorative and Hard Chrome Electroplating and Anodizing Operations</i> | IC/PCR | 3ea 2-hr tests | One field blank |
| Worker Protection - Area Samples | Time weighted Average | OSHA ID-215 | <i>Hexavalent Chromium in Workplace Atmospheres</i> | IC w/ UV-vis detector & post column delivery system | 6 samples 2 @ surface (+1-2"), 2 @ tank breathing zone (BZ), 2@ BZ zone (>10" away from tank | 1/every 5 samples submitted |
| One test event before and one after adding Fumetrol® 140 at NADEP Cherry Point, Tinker AFB, and North Island | | | | | | |
| Material Quality | Batch 1" x 4" x 0.040" coupons | Fed Spec QQ-C-320B(4) | <i>Chromium Plating (electrodeposited)</i> | Thickness Adhesion Hardness Porosity | 10 samples/per test type / site (40 samples per test site) | pass/fail |
| Material Quality | Batch, Notched round bars | Fed Spec QQ-C-320B(4) | Sustained tensile load per ASTM F 519-97 | Hydrogen Embrittlement | 10 samples/per test type / site | pass/fail |
| Material Quality | Batch, Notched round bars | Fed Spec QQ-C-320B(4) | Rising step load per ASTM F 519-97 and ASTM F 1624 | Hydrogen Embrittlement | 10 samples/per test type / site | pass/ fail |
| Recorded during testing and Records reviewed during testing period | | | | | | |
| Surface Tension | Grab | ASTM D1331-89 | <i>Tensiometric</i> | Tensiometer | Per 40 CFR 63 | |
| Other | Grab | | <i>amp-hours, voltage, amps, bath temperature</i> | | | Per instrument instructions |

Table D-2 - Detailed Test Plan WA/FS Material Quality Testing

| Test | Specimens | Method | References | Number of Samples | | | | | Test Performer |
|--------------------------------------|---|--|-------------------------|-----------------------------|-----------------------------|----------------------------|--------------------------------------|------------------------------------|-----------------------|
| | | | | North Island w/WA/FS | Tinker AFB w/o WA/FS | Tinker AFB w/ WA/FS | NADE P Cherry Point w/o WA/FS | NADEP Cherry Point w/ WA/FS | |
| Hydrogen Embrittlement Relief | 4340 notched round bars per ASTM F 519-97 | Sustained load per ASTM F 519-97 | QQ-C-320B | 10 | 10 | 10 | 10 | 10 | Pax Materials Lab |
| Hydrogen Embrittlement Relief | 4340 notched round bars per ASTM F 519-97 | Rising step load per ASTM F 519-97 and ASTM F 1624 | QQ-C-320B | 10 | 10 | 10 | 10 | 10 | Pax Materials Lab |
| Thickness | 4130, 1" by 4" by 0.040" | Magnetic thickness testing per ASTM B 499 | QQ-C-320B section 4.5.1 | 10 | 10 | 10 | 10 | 10 | Pax Materials Lab |
| Adhesion | 4130, 1" by 4" by 0.040" | Mandrel bend test ASTM B 571-97 section 3.1 | QQ-C-320B section 4.5.2 | 10 | 10 | 10 | 10 | 10 | NI Materials Lab |
| Hardness | 4130, 1" by 4" by 0.040" | Vickers hardness test per ASTM B 578 | QQ-C-320B section 4.5.3 | 10 | 10 | 10 | 10 | 10 | NI Materials Lab |
| Porosity | 4130, 3" by 10" by 0.040" | Ferroxyl test per QQ-C-320B section 4.5.4 | QQ-C-320B section 4.5.4 | 10 | 10 | 10 | 10 | 10 | Pax Materials Lab |

Table D-3 - Sample Location Schedule

| Sample Sites | Air Emission Tests | Start Date |
|----------------------------------|-------------------------------------|-------------------|
| NADEP Cherry Point | w/o WA/FS, & w/polyethylene shield* | 11 Jul 2000 |
| | w/o WA/FS | 12 Jul 2000 |
| | w/ WA/FS | 21 Sep 2000 |
| | w/o WA/FS | 15 Nov 2000 |
| | w/ WA/FS | 16 Nov 2000 |
| | w/ WA/FS | 13 Dec 2000 |
| | w/ WA/FS | 27 Mar 2001 |
| | w/ WA/FS | 17 Apr 2001 |
| Tinker AFB Air Force Base | w/o WA/FS | 12 Sep 2000 |
| | w/ WA/FS | 11 Oct 2000 |
| | w/ WA/FS | 8 Nov 2000 |
| | w/ WA/FS | 6 Dec 2000 |
| | w/ WA/FS | 31 Jul 2001 |
| | w/ WA/FS | 1 Aug 2001 |

* The first day at NADEP Cherry Point was the only time and location that the polyethylene shield was used.

| Table D-4. SUMMARY OF RESULTS - NADEP Cherry Point, NC, Tank No. 155 Stack Test, 11/12 July 2000 | | | | | | |
|--|--------|--------|--------|--------|--------|--------|
| Run Number | 1* | 2 | 3 | 4 | 5 | 6 |
| Field Data Inputs: | | | | | | |
| Barrier in Place (Y or N) | N | N | N | Y | Y | Y |
| Fume Suppressant in Use (Y or N). If Y, then Surface Tension (dynes/cm) | N | N | N | N | N | N |
| Bath Surface Area (ft ²) | 21.5 | 21.5 | 21.5 | 21.5 | 21.5 | 21.5 |
| Bath Freeboard (inches) | 8.0 | 8.0 | 8.0 | 8.0 | 8.0 | 8.0 |
| Exhaust Intake Area (ft ²) | 3.22 | 3.22 | 3.22 | 3.22 | 3.22 | 3.22 |
| Barometric Pressure (in.Hg) - P _b | 29.86 | 29.86 | 29.86 | 29.94 | 29.94 | 29.94 |
| Stack Diameter (ft.) - D _s | 1.667 | 1.667 | 1.667 | 1.667 | 1.667 | 1.667 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) - Δ P | 0.48 | 0.52 | 0.54 | 0.47 | 0.53 | 0.50 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.67 | 0.72 | 0.72 | 0.68 | 0.71 | 0.69 |
| Stack Temperature (EF) - T _s | 88 | 91 | 92 | 84 | 86 | 88 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.4 | -2.8 | -2.8 | -2.5 | -2.5 | -3.0 |
| Absolute Pressure (in.Hg) - P _a | 29.68 | 29.65 | 29.65 | 29.76 | 29.76 | 29.72 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 88.36 | 55.49 | 55.8 | 52.75 | 56.22 | 53.85 |
| Average Dry Gas Meter Temperature (EF) - T _m | 92 | 93 | 95 | 88 | 90 | 91.5 |
| Dry Gas Meter Cal. Factor (dimensionless) | 1.0089 | 1.0089 | 1.0089 | 1.0089 | 1.0089 | 1.0089 |
| Orifice)H _@ (in.H ₂ O) | 1.7260 | 1.7260 | 1.7260 | 1.7260 | 1.7260 | 1.7260 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 1.75 | 0.65 | 0.68 | 0.57 | 0.65 | 0.60 |
| Water Collected (gm) - V _{lc} | 106.0 | 29.6 | 28.5 | 25.5 | 28.1 | 25.8 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 | 120 | 120 | 121.5 |
| Nozzle Diameter (inches) - D _n | 0.250 | 0.1875 | 0.1875 | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 370 | 430 | 440 | 480 | 505 | 490 |

Table D-4. NADEP Cherry Point – 11/12 July – (Continued)

| Flow Results: | | | | | | |
|--|-------|--------|--------|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 38.80 | 41.59 | 41.62 | 38.94 | 40.74 | 39.68 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 85.43 | 53.33 | 53.52 | 51.36 | 54.55 | 52.11 |
| Moisture in Sample (as a gas, ft ³) – M | 4.98 | 1.39 | 1.34 | 1.20 | 1.32 | 1.21 |
| Moisture in Sample (%) - M_p | 5.51 | 2.54 | 2.44 | 2.28 | 2.36 | 2.27 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.39 | 28.72 | 28.73 | 28.75 | 28.74 | 28.75 |
| Stack Area (ft ²) – A | 2.18 | 2.18 | 2.18 | 2.18 | 2.18 | 2.18 |
| Actual Stack Flow Rate (acfm) - Q_a | 5,080 | 5,440 | 5,450 | 5,100 | 5,330 | 5,190 |
| Standard Stack Flow Rate (scfm) - Q_s | 4,860 | 5,170 | 5,170 | 4,920 | 5,130 | 4,970 |
| Dry Standard Stack Flow (dscfm) - Q_d | 4,590 | 5,040 | 5,040 | 4,810 | 5,010 | 4,860 |
| Isokinetic Rate (% of Isokinetic) - I | 99.20 | 100.21 | 100.57 | 101.14 | 103.14 | 100.29 |
| Laboratory Analysis: | | | | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.46 | 23.9 | 2.94 | 12.3 | 2.81 | 4.70 |
| Hex.Chromium Concentration (mg/l) - C_h | 0.31 | 22.2 | 2.54 | 9.47 | 2.79 | 4.12 |
| Percent Hexavalent Chromium (%) | 67.4 | 92.9 | 86.4 | 77.0 | 99.3 | 87.7 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.170 | 10.28 | 1.29 | 5.90 | 1.42 | 2.30 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.115 | 9.55 | 1.12 | 4.55 | 1.41 | 2.02 |

Table D-4. NADEP Cherry Point - 11/12 July - (Continued)

| Operational Parameters: | | | | | | |
|--|------------|------------|------------|--------|--------|--------|
| Volts – E | not avail. | not avail. | not avail. | 6.08 | 6.07 | 6.07 |
| Average Amperes – AM | not avail. | not avail. | not avail. | 1,341 | 1,476 | 1,466 |
| Ampere-Hours (Amp-hr) – AH | not avail. | 1,891 | 525 | 3,055 | 3,378 | 3,138 |
| Hours Between AH Meter Readings - 2_{AH} | not avail. | 1.6 | 2.2 | 2.4 | 2.4 | 2.1 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | not avail. | 2,363 | 477 | 2,546 | 2,815 | 2,989 |
| Emission Results: | | | | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.00199 | 0.193 | 0.0242 | 0.115 | 0.0260 | 0.0442 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.00134 | 0.179 | 0.0209 | 0.0885 | 0.0258 | 0.0387 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.0703 | 6.804 | 0.853 | 4.06 | 0.919 | 1.56 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.0454 | 6.32 | 0.737 | 3.13 | 0.912 | 1.37 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | not avail. | 49.3 | 30.6 | 26.1 | 5.55 | 8.73 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | not avail. | 45.8 | 26.5 | 20.1 | 5.51 | 7.65 |

Note:

* For run number 1 there was no electroplating load in the plating bath (i.e., nothing was being electroplated). Consequently, the emissions data from only runs 2 and 3 were used to determine average emissions results for 11 July 2000.

| Table D-5 SUMMARY OF RESULTS - NADEP Cherry Point, NC, Tank No. 155 Stack Test, 21 Sep 2000 | | | |
|--|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). | Y | Y | Y |
| If Y, then Surface Tension (dynes/cm) | 33 | 33 | 33 |
| Bath Surface Area (ft ²) | 21.5 | 21.5 | 21.5 |
| Bath Freeboard (inches) | 8.0 | 8.0 | 8.0 |
| Exhaust Intake Area (ft ²) | 3.22 | 3.22 | 3.22 |
| Barometric Pressure (in.Hg) - P _b | 29.94 | 29.94 | 29.94 |
| Stack Diameter (ft.) - D _s | 1.667 | 1.667 | 1.667 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) - Δ P | 0.94 | 0.96 | 0.94 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.96 | 0.97 | 0.96 |
| Stack Temperature (EF) - T _s | 87 | 90 | 90 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.7 | -2.7 | -2.7 |
| Absolute Pressure (in.Hg) - P _a | 29.74 | 29.74 | 29.74 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 73.984 | 74.253 | 74.771 |
| Average Dry Gas Meter Temperature (EF) - T _m | 92 | 98 | 99 |
| Dry Gas Meter Cal. Factor (dimensionless) | 0.9956 | 0.9956 | 0.9956 |
| Orifice)H _@ (in.H ₂ O) | 1.8475 | 1.8475 | 1.8475 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 1.13 | 1.24 | 1.25 |
| Water Collected (gm) - V _{lc} | 41.1 | 38.0 | 42.2 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) - D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 389 | 447 | 451 |

Table D-5. NADEP Cherry Point - 21 Sep - (Continued)

| Flow Results: | | | |
|--|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 55.18 | 55.89 | 55.34 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 70.67 | 70.18 | 70.55 |
| Moisture in Sample (as a gas, ft ³) - M | 1.93 | 1.79 | 1.98 |
| Moisture in Sample (%) - M_p | 2.66 | 2.48 | 2.74 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.71 | 28.73 | 28.70 |
| Stack Area (ft ²) - A | 2.18 | 2.18 | 2.18 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,220 | 7,320 | 7,240 |
| Standard Stack Flow Rate (scfm) - Q_s | 6,930 | 6,980 | 6,910 |
| Dry Standard Stack Flow (dscfm) - Q_d | 6,750 | 6,810 | 6,730 |
| Isokinetic Rate (% of Isokinetic) - I | 99.18 | 97.60 | 99.34 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.248 | 0.163 | 0.105 |
| Hex.Chromium Concentration (mg/l) - C_h | 0.215 | 0.133 | 0.0959 |
| Percent Hexavalent Chromium (%) | 86.7 | 81.6 | 91.3 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.0965 | 0.729 | 0.474 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.0836 | 0.0595 | 0.0433 |

Table D-5. NADEP Cherry Point - 21 Sep - (Continued)

| Operational Parameters: | | | |
|---|---------|----------|----------|
| Volts – E | 5.0 | 5.0 | 5.0 |
| Average Amperes – AM | 1,245 | 1,245 | 1,225 |
| Ampere-Hours (Amp-hr) - AH | 3,268 | 3,268 | 2,589 |
| Hours Between AH Meter Readings - 2_{AH} | 2.1 | 2.1 | 2.2 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | 3,112 | 3,112 | 2,354 |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.00137 | 0.00104 | 0.000671 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.00118 | 0.000847 | 0.000613 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.0482 | 0.0367 | 0.0237 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.0418 | 0.0299 | 0.0216 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.355 | 0.273 | 0.230 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.308 | 0.222 | 0.210 |

| Table D-6. SUMMARY OF RESULTS - NADEP Cherry Point, NC, Tank No. 155 Stack Test, 15/16 Nov 2000 | | | | | | |
|--|--------|--------|--------|-----------|-----------|-----------|
| Run Number | 1 | 2 | 3 | 4 | 5 | 6 |
| Field Data Inputs: | | | | | | |
| Barrier in Place (Y or N) | N | N | N | N | N | N |
| Fume Suppressant in Use (Y or N). If Y, then Surface Tension (dynes/cm) | N | N | N | Y 23.1 | Y 23.1 | Y 23.1 |
| Bath Surface Area (ft ²) | 21.5 | 21.5 | 21.5 | 21.5 | 21.5 | 21.5 |
| Bath Freeboard (inches) | 8.0 | 8.0 | 8.0 | 8.0 | 8.0 | 8.0 |
| Exhaust Intake Area (ft ²) | 3.22 | 3.22 | 3.22 | 3.22 | 3.22 | 3.22 |
| Barometric Pressure (in.Hg) - P _b | 30.03 | 30.03 | 30.03 | 30.13 | 30.13 | 30.13 |
| Stack Diameter (ft.) - D _s | 1.667 | 1.667 | 1.667 | 1.667 | 1.667 | 1.667 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) - Δ P | 0.76 | 0.71 | 0.59 | 0.90 | 0.95 | 0.87 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.86 | 0.83 | 0.76 | 0.93 | 0.96 | 0.92 |
| Stack Temperature (EF) - T _s | 62.0 | 64.1 | 63.8 | 60.9 | 66.7 | 67.3 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.5 | -2.5 | -2.5 | -2.7 | -2.7 | -2.7 |
| Absolute Pressure (in.Hg) - P _a | 29.85 | 29.85 | 29.85 | 29.93 | 29.93 | 29.93 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 53.759 | 53.644 | 48.637 | 59.762 | 62.412 | 59.827 |
| Average Dry Gas Meter Temperature (EF) - T _m | 67.2 | 68.6 | 69.7 | 66.9 | 72.8 | 73.5 |
| Dry Gas Meter Cal. Factor (dimensionless) | 1.0043 | 1.0043 | 1.0043 | 1.0043 | 1.0043 | 1.0043 |
| Orifice)H _@ (in.H ₂ O) | 1.6696 | 1.6696 | 1.6696 | 1.6696 | 1.6696 | 1.6696 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 0.91 | 0.86 | 0.72 | 1.10 | 1.15 | 1.07 |
| Water Collected (gm) - V _{lc} | 7.2 | 7.0 | 7.0 | 10.8 | 15.4 | 12.8 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 | 120 | 120 | 120 |
| Nozzle Diameter (inches) - D _n | 0.1875 | 0.1875 | 0.1875 | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 379 | 379 | 360 | 372 | 396 | 343 |

Table D-6. NADEP Cherry Point – 15/16 Nov - (Continued)

| Flow Results: | | | | | | |
|--|-------|-------|-------|--------|--------|-------|
| Average Stack Velocity (ft/sec) - V_s | 48.02 | 46.43 | 42.51 | 51.82 | 53.82 | 51.59 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 54.37 | 54.10 | 48.94 | 60.71 | 62.70 | 60.02 |
| Moisture in Sample (as a gas, ft ³) – M | 0.338 | 0.329 | 0.329 | 0.508 | 0.724 | 0.602 |
| Moisture in Sample (%) - M_p | 0.619 | 0.604 | 0.668 | 0.829 | 1.14 | 0.992 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.93 | 28.93 | 28.93 | 28.91 | 28.87 | 28.90 |
| Stack Area (ft ²) – A | 2.18 | 2.18 | 2.18 | 2.18 | 2.18 | 2.18 |
| Actual Stack Flow Rate (acfm) - Q_a | 6,290 | 6,080 | 5,560 | 6,780 | 7,050 | 6,750 |
| Standard Stack Flow Rate (scfm) - Q_s | 6,340 | 6,110 | 5,600 | 6,880 | 7,070 | 6,770 |
| Dry Standard Stack Flow (dscfm) - Q_d | 6,300 | 6,070 | 5,560 | 6,820 | 6,990 | 6,700 |
| Isokinetic Rate (% of Isokinetic) - I^* | 81.7 | 84.4 | 83.4 | 84.3 | 85.0 | 84.8 |
| Laboratory Analysis: | | | | | | |
| Total Chromium Concentration (mg/l) - C_t | 6.37 | 5.30 | 4.65 | 0.199 | 0.212 | 0.336 |
| Hex. Chromium Concentration (mg/l) - C_h | 6.04 | 5.25 | 4.84 | 0.206 | 0.216 | 0.336 |
| Percent Hexavalent Chromium (%) | 94.8 | 99.1 | 104.1 | 103.5 | 101.9 | 100.0 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 2.41 | 2.01 | 1.67 | 0.0740 | 0.0840 | 0.115 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 2.29 | 1.99 | 1.74 | 0.0766 | 0.0855 | 0.115 |

Note:

- Isokineticity was uniformly low due to a foreign object that had lodged in the critical orifice of the stack sampling apparatus.

Table D-6. NADEP Cherry Point – 15/16 Nov - (Continued)

| Operational Parameters: | | | | | | |
|--|--------|--------|--------|---------|---------|---------|
| Volts – E | 4.84 | 4.82 | 4.81 | 4.82 | 4.82 | 4.81 |
| Average Amperes – AM | 1,260 | 1,296 | 1,278 | 1,274 | 1,274 | 1,324 |
| Ampere-Hours (Amp-hr) - AH | 2,956 | 2,928 | 3,003 | 2,760 | 2,755 | 2,859 |
| Hours Between AH Meter Readings - 2_{AH} | 2.15 | 2.3 | 2.3 | 2.15 | 2.2 | 2.2 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | 2,750 | 2,546 | 2,611 | 2,567 | 2,505 | 2,599 |
| Emission Results: | | | | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.0444 | 0.0371 | 0.0342 | 0.00122 | 0.00134 | 0.00192 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.0421 | 0.0368 | 0.0356 | 0.00126 | 0.00136 | 0.00192 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 1.57 | 1.31 | 1.21 | 0.0431 | 0.0473 | 0.0678 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 1.49 | 1.30 | 1.26 | 0.0446 | 0.0482 | 0.0678 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 12.2 | 10.6 | 8.74 | 0.389 | 0.448 | 0.594 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 11.58 | 10.53 | 9.10 | 0.403 | 0.457 | 0.594 |

| Table D-7. SUMMARY OF RESULTS - NADEP Cherry Point, NC, Tank No. 155 Stack Test, 13 DEC 00 | | | |
|---|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). | Y | Y | Y |
| If Y, then Surface Tension (dynes/cm) | 23.4 | 23.4 | 23.4 |
| Bath Surface Area (ft ²) | 21.5 | 21.5 | 21.5 |
| Bath Freeboard (inches) | 8.0 | 8.0 | 8.0 |
| Exhaust Intake Area (ft ²) | 3.22 | 3.22 | 3.22 |
| Barometric Pressure (in.Hg) - P _b | 30.50 | 30.50 | 30.50 |
| Stack Diameter (ft.) - D _s | 1.667 | 1.667 | 1.667 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) - Δ P | 0.65 | 0.87 | 0.73 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.79 | 0.92 | 0.83 |
| Stack Temperature (EF) - T _s | 63.6 | 67.5 | 68.1 |
| Stack Static Pressure (in.H ₂ O) - P _s | -1.6 | -2.1 | -2.1 |
| Absolute Pressure (in.Hg) - P _a | 30.38 | 30.35 | 30.35 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 58.532 | 67.784 | 62.900 |
| Average Dry Gas Meter Temperature (EF) - T _m | 69.2 | 73.9 | 75.1 |
| Dry Gas Meter Cal. Factor (dimensionless) | 1.0086 | 1.0086 | 1.0086 |
| Orifice)H _@ (in.H ₂ O) | 1.8199 | 1.8199 | 1.8199 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 0.85 | 1.16 | 0.98 |
| Water Collected (gm) - V _{lc} | 2.3 | 5.7 | 8.2 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) - D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 319 | 356 | 364 |

Table D-7 NADEP Cherry Point – 13 December - (Continued)

| Flow Results: | | | |
|--|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 43.75 | 51.19 | 46.23 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 60.14 | 69.09 | 63.94 |
| Moisture in Sample (as a gas, ft^3) - M | 0.108 | 0.268 | 0.385 |
| Moisture in Sample (%) - M_p | 0.179 | 0.386 | 0.599 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 28.71 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.98 | 28.96 | 28.93 |
| Stack Area (ft^2) - A | 2.18 | 2.18 | 2.18 |
| Actual Stack Flow Rate (acfm) - Q_a | 5,730 | 6,700 | 6,050 |
| Standard Stack Flow Rate (scfm) - Q_s | 5,870 | 6,800 | 6,140 |
| Dry Standard Stack Flow (dscfm) - Q_d | 5,850 | 6,780 | 6,100 |
| Isokinetic Rate (% of Isokinetic) - I | 97.27 | 96.53 | 99.25 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.103 | 0.159 | 0.121 |
| Hex.Chromium Concentration (mg/l) - C_h | 0.0906 | 0.150 | 0.116 |
| Percent Hexavalent Chromium (%) | 88.0 | 94.3 | 95.9 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.0329 | 0.0566 | 0.0440 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.0289 | 0.0534 | 0.0422 |

Table D-7 NADEP Cherry Point – 13 December - (Continued)

| Operational Parameters: | | | |
|---|----------|----------|----------|
| Volts – E | 6.03 | 6.01 | 6.01 |
| Average Amperes – AM | 848 | 872 | 886 |
| Ampere-Hours (Amp-hr) - AH | 1,836 | 1,888 | 1,789 |
| Hours Between AH Meter Readings - 2_{AH} | 2.15 | 2.2 | 2.1 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | 1,708 | 1,716 | 1,704 |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.000546 | 0.000819 | 0.000689 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.000481 | 0.000773 | 0.000660 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.0193 | 0.0289 | 0.0243 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.0170 | 0.0273 | 0.0233 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.225 | 0.388 | 0.296 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.198 | 0.366 | 0.284 |

| Table D-8. SUMMARY OF RESULTS - NADEP Cherry Point, NC, Tank No. 155 Stack Test, 27 MAR 01 | | | |
|---|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). | Y | Y | Y |
| If Y, then Surface Tension (dynes/cm) | 27 | 27 | 27 |
| Bath Surface Area (ft ²) | 21.5 | 21.5 | 21.5 |
| Bath Freeboard (inches) | 8.0 | 8.0 | 8.0 |
| Exhaust Intake Area (ft ²) | 3.22 | 3.22 | 3.22 |
| Barometric Pressure (in.Hg) - P _b | 30.20 | 30.20 | 30.20 |
| Stack Diameter (ft.) - D _s | 1.667 | 1.667 | 1.667 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) – Δ P | 1.12 | 1.18 | 1.16 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 1.05 | 1.07 | 1.06 |
| Stack Temperature (EF) - T _s | 61.2 | 64.9 | 67.8 |
| Stack Static Pressure (in.H ₂ O) - P _s | -3.0 | -3.0 | -3.0 |
| Absolute Pressure (in.Hg) - P _a | 29.98 | 29.98 | 29.98 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 75.823 | 82.914 | 82.402 |
| Average Dry Gas Meter Temperature (EF) - T _m | 63.2 | 66.1 | 63.0 |
| Dry Gas Meter Cal. Factor (dimensionless) | 0.9922 | 0.9922 | 0.9922 |
| Orifice)H _@ (in.H ₂ O) | 1.7101 | 1.7101 | 1.7101 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 1.38 | 1.49 | 1.46 |
| Water Collected (gm) - V _{lc} | 0.0 | 0.4 | 0.6 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) – D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 323 | 393 | 413 |

Table D-8. NADEP Cherry Point – 27 March – (Continued)

| Flow Results: | | | |
|---|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 58.38 | 59.71 | 59.31 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 76.859 | 83.606 | 83.576 |
| Moisture in Sample (as a gas, ft^3) - M | 0.000 | 0.019 | 0.028 |
| Moisture in Sample (%) - M_p | 0.000 | 0.022 | 0.034 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 29.00 | 29.00 | 29.00 |
| Stack Area (ft^2) - A | 2.18 | 2.18 | 2.18 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,640 | 7,820 | 7,760 |
| Standard Stack Flow Rate (scfm) - Q_s | 7,760 | 7,880 | 7,780 |
| Dry Standard Stack Flow (dscfm) - Q_d | 7,760 | 7,880 | 7,780 |
| Isokinetic Rate (% of Isokinetic) - I | 93.80 | 100.50 | 101.70 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.240 | 0.325 | 0.200 |
| Hex. Chromium Concentration (mg/l) - C_h | 0.211 | 0.321 | 0.158 |
| Percent Hexavalent Chromium (%) | 87.9 | 98.8 | 79.0 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt0} | 0.0775 | 0.1277 | 0.0826 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.0682 | 0.126 | 0.0653 |

Table D-8. NADEP Cherry Point – 27 March – (Continued)

| Operational Parameters: | | | |
|---|----------|---------|----------|
| Volts – E | 5.01 | 5.0 | 5.0 |
| Average Amperes – AM | 1,479 | 1,492 | 1,498 |
| Ampere-Hours (Amp-hr) - AH | 3,325 | 3,295 | 3,179 |
| Hours between AH Meter Readings - 2_{AH} | 2.2 | 2.25 | 2.2 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | 3,023 | 2,929 | 2,890 |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.00101 | 0.00153 | 0.000988 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.000887 | 0.00151 | 0.000781 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.0356 | 0.0539 | 0.0349 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.0313 | 0.0533 | 0.0276 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.311 | 0.493 | 0.319 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.273 | 0.487 | 0.252 |

| Table D-9. SUMMARY OF RESULTS - NADEP Cherry Point, NC, Tank No. 155 Stack Test, 17 April 01 | | | |
|--|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). | Y | Y | Y |
| If Y, then Surface Tension (dynes/cm) | 27 | 27 | 27 |
| Bath Surface Area (ft ²) | 21.5 | 21.5 | 21.5 |
| Bath Freeboard (inches) | 8.0 | 8.0 | 8.0 |
| Exhaust Intake Area (ft ²) | 3.22 | 3.22 | 3.22 |
| Barometric Pressure (in.Hg) - P _b | 29.80 | 29.80 | 29.80 |
| Stack Diameter (ft.) - D _s | 1.667 | 1.667 | 1.667 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) - Δ P | 1.02 | 1.07 | 1.12 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.99 | 1.02 | 1.05 |
| Stack Temperature (EF) - T _s | 72.0 | 72.0 | 70.2 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.8 | -2.8 | -3.2 |
| Absolute Pressure (in.Hg) - P _a | 29.59 | 29.59 | 29.56 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 75.745 | 81.579 | 83.573 |
| Average Dry Gas Meter Temperature (EF) - T _m | 79.6 | 80.9 | 78.9 |
| Dry Gas Meter Cal. Factor (dimensionless) | 0.9922 | 0.9922 | 0.9922 |
| Orifice)H _@ (in.H ₂ O) | 1.7101 | 1.7101 | 1.7101 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 1.26 | 1.35 | 1.42 |
| Water Collected (gm) - V _{lc} | 8.8 | 10.4 | 11.3 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) - D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 369 | 369 | 370 |

Table D-9: NADEP Cherry Point – 17 April – (Continued)

| Flow Results: | | | |
|--|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 56.03 | 57.74 | 59.37 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 73.442 | 78.926 | 81.169 |
| Moisture in Sample (as a gas, ft^3) - M | 0.414 | 0.489 | 0.531 |
| Moisture in Sample (%) - M_p | 0.560 | 0.616 | 0.650 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 29.94 | 29.93 | 29.93 |
| Stack Area (ft^2) - A | 2.18 | 2.18 | 2.18 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,340 | 7,560 | 7,770 |
| Standard Stack Flow Rate (scfm) - Q_s | 7,200 | 7,420 | 7,650 |
| Dry Standard Stack Flow (dscfm) - Q_d | 7,160 | 7,380 | 7,600 |
| Isokinetic Rate (% of Isokinetic) - I | 97.11 | 101.34 | 101.15 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.123 | 0.0990 | 0.130 |
| Hex. Chromium Concentration (mg/l) - C_h | 0.121 | 0.0925 | 0.127 |
| Percent Hexavalent Chromium (%) | 98.4 | 93.4 | 97.7 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.0454 | 0.0365 | 0.0481 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.0446 | 0.0341 | 0.0470 |

Table D-9. NADEP Cherry Point – 17 April – (Continued)

| Operational Parameters: | | | |
|---|----------|----------|----------|
| Volts – E | 4.99 | 4.98 | 4.98 |
| Average Amperes – AM | 939 | 979 | 990 |
| Ampere-Hours (Amp-hr) - AH | 2,105 | 1,991 | 2,011 |
| Hours between AH Meter Readings - 2_{AH} | 2.3 | 2.1 | 2.1 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | 1,830 | 1,896 | 1,915 |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.000618 | 0.000463 | 0.000593 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.000608 | 0.000432 | 0.000579 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.0218 | 0.0163 | 0.0209 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.0215 | 0.0153 | 0.0204 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.290 | 0.216 | 0.282 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.285 | 0.202 | 0.276 |

| Table D-10: SUMMARY OF RESULTS - Tinker AFB , Tank No. 222, 12 Sep 00 | | | |
|---|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). If Y, then Surface Tension (dynes/cm) | N | N | N |
| Bath Surface Area (ft ²) | 26.8 | 26.8 | 26.8 |
| Bath Freeboard (inches) | 7.5 | 7.5 | 7.5 |
| Exhaust Intake Area (ft ²) | 2.65 | 2.65 | 2.65 |
| Barometric Pressure (in.Hg) - P _b | 29.87 | 29.87 | 29.92 |
| Stack Diameter (ft.) - D _s | 1.83 | 1.83 | 1.83 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) – Δ P | 0.77 | 0.75 | 0.79 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.87 | 0.86 | 0.88 |
| Stack Temperature (EF) - T _s | 78.6 | 89.2 | 93.9 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.3 | -2.3 | -2.3 |
| Absolute Pressure (in.Hg) - P _a | 29.70 | 29.70 | 29.75 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 69.104 | 68.361 | 70.546 |
| Average Dry Gas Meter Temperature (EF) - T _m | 85.6 | 97.5 | 103.9 |
| Dry Gas Meter Cal. Factor (dimensionless) | 0.9956 | 0.9956 | 0.9956 |
| Orifice)H _@ (in.H ₂ O) | 1.8475 | 1.8475 | 1.8475 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 1.00 | 0.953 | 1.05 |
| Water Collected (gm) - V _{lc} | 22 | 32 | 54 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) – D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 475 | 475 | 470 |

Table D-10. Tinker AFB – 12 September - (Continued)

| | | | |
|--|-------|-------|-------|
| Flow Results: | | | |
| Average Stack Velocity (ft/sec) - V_s | 49.55 | 49.53 | 50.99 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 66.61 | 64.48 | 65.91 |
| Moisture in Sample (as a gas, ft^3) - M | 1.03 | 1.50 | 2.54 |
| Moisture in Sample (%) - M_p | 1.53 | 2.28 | 3.71 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.83 | 28.75 | 28.59 |
| Stack Area (ft^2) - A | 2.64 | 2.64 | 2.64 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,850 | 7,850 | 8,080 |
| Standard Stack Flow Rate (scfm) - Q_s | 7,640 | 7,490 | 7,660 |
| Dry Standard Stack Flow (dscfm) - Q_d | 7,520 | 7,320 | 7,370 |
| Isokinetic Rate (% of Isokinetic) - I | 101.5 | 101.0 | 102.4 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 2.56 | 1.28 | 1.76 |
| Hex.Chromium Concentration (mg/l) - C_h | 2.05 | 1.10 | 1.38 |
| Percent Hexavalent Chromium (%) | 80.1 | 85.9 | 78.4 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 1.22 | 0.608 | 0.827 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.974 | 0.523 | 0.649 |

Table D-10. Tinker AFB – 12 September - (Continued)

| Operational Parameters: | | | |
|---|--------|---------|---------|
| Volts (average of 3 bath sections) - E | 1.77 | 3.89 | 3.76 |
| Average Amperes (avg. of 3 bath sections) - AM | 131 | 118 | 120 |
| Ampere-Hours (Amp-hr) (total of 3 bath sections) - AH | 3,174 | 25,516 | 18,054 |
| Hours Between AH Meter Readings - 2_{AH} | n/a | n/a | n/a |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | n/a | n/a | n/a |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.0183 | 0.00943 | 0.0126 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.0146 | 0.00810 | 0.00984 |
| Total Chromium Exhaust Conc. (Mg/dscm) - C_{st} | 0.645 | 0.333 | 0.443 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.516 | 0.286 | 0.347 |
| Total Chromium Emitted/Amp-Hr (mg/Am-hr) - CAH_t | 5.19 | 0.324 | 0.615 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 4.16 | 0.279 | 0.482 |

| Table D-11 SUMMARY OF RESULTS - Tinker AFB, Tank No. 222, 11 Oct 00 | | | |
|---|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). | Y | Y | Y |
| If Y, then Surface Tension (dynes/cm) | 34 | 34 | 34 |
| Bath Surface Area (ft ²) | 26.8 | 26.8 | 26.8 |
| Bath Freeboard (inches) | 7.5 | 7.5 | 7.5 |
| Exhaust Intake Area (ft ²) | 2.65 | 2.65 | 2.65 |
| Barometric Pressure (in.Hg) - P _b | 30.22 | 30.22 | 30.22 |
| Stack Diameter (ft.) - D _s | 1.83 | 1.83 | 1.83 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) – Δ P | 0.76 | 0.78 | 0.80 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.87 | 0.87 | 0.89 |
| Stack Temperature (EF) - T _s | 65.6 | 70.6 | 76.0 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.3 | -2.3 | -2.3 |
| Absolute Pressure (in.Hg) - P _a | 30.05 | 30.05 | 30.05 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 65.995 | 67.006 | 69.390 |
| Average Dry Gas Meter Temperature (EF) - T _m | 76.2 | 84.4 | 92.9 |
| Dry Gas Meter Cal. Factor (dimensionless) | 1.0092 | 1.0092 | 1.0092 |
| Orifice)H _@ (in.H ₂ O) | 1.7398 | 1.7398 | 1.7398 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 0.95 | 1.00 | 1.04 |
| Water Collected (gm) - V _{lc} | 4.3 | 8.6 | 10.8 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) – D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 366 | 380 | 341 |

Table D-11. Tinker AFB – 11 October - (Continued)

| Flow Results: | | | |
|--|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 48.55 | 48.81 | 50.19 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 66.37 | 66.38 | 67.69 |
| Moisture in Sample (as a gas, ft^3) - M | 0.202 | 0.404 | 0.508 |
| Moisture in Sample (%) - M_p | 0.304 | 0.605 | 0.744 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.97 | 28.93 | 28.92 |
| Stack Area (ft^2) - A | 2.64 | 2.64 | 2.64 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,690 | 7,730 | 7,950 |
| Standard Stack Flow Rate (scfm) - Q_s | 7,760 | 7,730 | 7,870 |
| Dry Standard Stack Flow (dscfm) - Q_d | 7,740 | 7,680 | 7,810 |
| Isokinetic Rate (% of Isokinetic) - I | 98.30 | 99.02 | 99.32 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.0457 | 0.0620 | 0.0625 |
| Hex.Chromium Concentration (mg/l) - C_h | 0.0420 | 0.0516 | 0.0351 |
| Percent Hexavalent Chromium (%) | 91.9 | 83.2 | 56.2 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.0167 | 0.0236 | 0.0213 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.0154 | 0.0196 | 0.0120 |

Table D-11. Tinker AFB – 11 October - (Continued)

| Operational Parameters: | | | |
|---|----------|----------|----------|
| Volts (average of 3 bath sections) - E | 4.99 | 4.84 | 4.76 |
| Average Amperes (avg. of 3 bath sections) - AM | 150 | 151 | 154 |
| Ampere-Hours (Amp-hr) (total of 3 bath sections) - AH | 9,392 | 9,903 | 10,062 |
| Hours Between AH Meter Readings - 2_{AH} | n/a | n/a | n/a |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | n/a | n/a | n/a |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.000252 | 0.000355 | 0.000315 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.000232 | 0.000295 | 0.000177 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.00890 | 0.0125 | 0.0111 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.00818 | 0.0104 | 0.00624 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.0249 | 0.0330 | 0.0293 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.0229 | 0.0275 | 0.0165 |

| Table D-12: SUMMARY OF RESULTS - Tinker AFB, Tank No. 222, 8 Nov 00 | | | |
|---|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). | Y | Y | Y |
| If Y, then Surface Tension (dynes/cm) | 27 | 27 | 27 |
| Bath Surface Area (ft ²) | 26.8 | 26.8 | 26.8 |
| Bath Freeboard (inches) | 7.5 | 7.5 | 7.5 |
| Exhaust Intake Area (ft ²) | 2.65 | 2.65 | 2.65 |
| Barometric Pressure (in.Hg) - P _b | 29.99 | 29.99 | 29.99 |
| Stack Diameter (ft.) - D _s | 1.83 | 1.83 | 1.83 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) – Δ P | 0.70 | 0.74 | 0.72 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.83 | 0.85 | 0.84 |
| Stack Temperature (EF) - T _s | 58.1 | 58.1 | 56.4 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.3 | -2.3 | -2.3 |
| Absolute Pressure (in.Hg) - P _a | 29.82 | 29.82 | 29.82 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 61.692 | 66.191 | 65.511 |
| Average Dry Gas Meter Temperature (EF) - T _m | 66.6 | 67.3 | 66.4 |
| Dry Gas Meter Cal. Factor (dimensionless) | 1.0043 | 1.0043 | 1.0043 |
| Orifice)H _@ (in.H ₂ O) | 1.6696 | 1.6696 | 1.6696 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 0.96 | 0.92 | 0.90 |
| Water Collected (gm) - V _{lc} | 6.8 | 8.1 | 10.3 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) – D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 387 | 348 | 369 |

Table D-12. Tinker AFB – 8 November - (Continued)

| Flow Results: | | | |
|--|--------|--------|---------|
| Average Stack Velocity (ft/sec) - V_s | 46.18 | 47.30 | 46.68 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 62.374 | 66.843 | 66.267 |
| Moisture in Sample (as a gas, ft^3) - M | 0.320 | 0.381 | 0.484 |
| Moisture in Sample (%) - M_p | 0.510 | 0.566 | 0.725 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.94 | 28.94 | 28.92 |
| Stack Area (ft^2) - A | 2.64 | 2.64 | 2.64 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,310 | 7,490 | 7,390 |
| Standard Stack Flow Rate (scfm) - Q_s | 7,430 | 7,610 | 7,540 |
| Dry Standard Stack Flow (dscfm) - Q_d | 7,390 | 7,570 | 7,480 |
| Isokinetic Rate (% of Isokinetic) - I | 96.67 | 101.21 | 101.49 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.0409 | 0.0349 | 0.0152 |
| Hex.Chromium Concentration (mg/l) - C_h | 0.0397 | 0.0389 | 0.0150 |
| Percent Hexavalent Chromium (%) | 97.1 | 111.5 | 98.7 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.0158 | 0.0121 | 0.00561 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.0154 | 0.0135 | 0.00554 |

Table D-12. Tinker AFB – 8 November - (Continued)

| Operational Parameters: | | | |
|---|----------|----------|-----------|
| Volts (average of 3 bath sections) - E | 3.81 | 3.99 | 4.00 |
| Average Amperes (avg. of 3 bath sections) - AM | 191 | 211 | 211 |
| Ampere-Hours (Amp-hr) (total of 3 bath sections) - AH | 24,360 | 24,395 | 24,423 |
| Hours Between AH Meter Readings - 2_{AH} | n/a | n/a | n/a |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | n/a | n/a | n/a |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.000254 | 0.000182 | 0.0000846 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.000246 | 0.000203 | 0.0000835 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.00896 | 0.00642 | 0.00299 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.00870 | 0.00715 | 0.00295 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.00924 | 0.00676 | 0.00311 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.00897 | 0.00754 | 0.00307 |

| Table D-13. SUMMARY OF RESULTS - Tinker AFB, Tank No. 222, 6 Dec 00 | | | |
|---|--------|--------|--------|
| Run Number | 1 | 2 | 3 |
| Field Data Inputs: | | | |
| Barrier in Place (Y or N) | N | N | N |
| Fume Suppressant in Use (Y or N). | Y | Y | Y |
| If Y, then Surface Tension (dynes/cm) | 30.5 | 30.5 | 30.5 |
| Bath Surface Area (ft ²) | 26.8 | 26.8 | 26.8 |
| Bath Freeboard (inches) | 7.5 | 7.5 | 7.5 |
| Exhaust Intake Area (ft ²) | 2.65 | 2.65 | 2.65 |
| Barometric Pressure (in.Hg) - P _b | 30.14 | 30.14 | 30.14 |
| Stack Diameter (ft.) - D _s | 1.83 | 1.83 | 1.83 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) – Δ P | 0.72 | 0.70 | 0.68 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.84 | 0.84 | 0.81 |
| Stack Temperature (EF) - T _s | 78.8 | 77.7 | 79.3 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.5 | -2.5 | -2.5 |
| Absolute Pressure (in.Hg) - P _a | 29.96 | 29.96 | 29.96 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 66.347 | 65.225 | 63.347 |
| Average Dry Gas Meter Temperature (EF) - T _m | 87.6 | 87.6 | 88.3 |
| Dry Gas Meter Cal. Factor (dimensionless) | 1.0086 | 1.0086 | 1.0086 |
| Orifice)H _@ (in.H ₂ O) | 1.8199 | 1.8199 | 1.8199 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 0.96 | 0.95 | 0.92 |
| Water Collected (gm) - V _{lc} | 3.5 | 5.6 | 6.4 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 |
| Nozzle Diameter (inches) – D _n | 0.1875 | 0.1875 | 0.1875 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 335 | 378 | 409 |

Table D-13. Tinker AFB – 6 December - (Continued)

| Flow Results: | | | |
|--|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 47.53 | 47.49 | 45.87 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 65.123 | 64.020 | 62.093 |
| Moisture in Sample (as a gas, ft^3) - M | 0.165 | 0.263 | 0.301 |
| Moisture in Sample (%) - M_p | 0.252 | 0.409 | 0.482 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.97 | 28.95 | 28.95 |
| Stack Area (ft^2) - A | 2.64 | 2.64 | 2.64 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,530 | 7,520 | 7,270 |
| Standard Stack Flow Rate (scfm) - Q_s | 7,390 | 7,400 | 7,120 |
| Dry Standard Stack Flow (dscfm) - Q_d | 7,370 | 7,370 | 7,090 |
| Isokinetic Rate (% of Isokinetic) - I | 101.3 | 99.6 | 100.4 |
| Laboratory Analysis: | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.132 | 0.103 | 0.0539 |
| Hex. Chromium Concentration (mg/l) - C_h | 0.129 | 0.0892 | 0.0457 |
| Percent Hexavalent Chromium (%) | 97.7 | 86.6 | 84.8 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.0442 | 0.0389 | 0.0220 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.0432 | 0.0337 | 0.0187 |

Table D-13. Tinker AFB – 6 December - (Continued)

| Operational Parameters: | | | |
|---|----------|----------|----------|
| Volts (average of 3 bath sections) - E | 4.93 | 4.90 | 4.87 |
| Average Amperes (avg. of 3 bath sections) - AM | 120 | 119 | 119 |
| Ampere-Hours (Amp-hr) (total of 3 bath sections) - AH | 19,821 | 12,682 | 19,676 |
| Hours Between AH Meter Readings - 2_{AH} | 2.0 | 0.625 | 2.0 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | 19,821 | 20,291 | 19,676 |
| Emission Results: | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.000679 | 0.000608 | 0.000355 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.000664 | 0.000527 | 0.000301 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.0240 | 0.0215 | 0.0125 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.0234 | 0.0186 | 0.0106 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.0303 | 0.0265 | 0.0153 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.0296 | 0.0229 | 0.0130 |

| Table D-14. SUMMARY OF RESULTS - Tinker AFB, Tank No. 222, - 31 July & 1 Aug 01 | | | | | | |
|--|--------------|--------------|--------------|------------|------------|------------|
| Run Number | 1 31 July | 2 31 July | 3 31 July | 4 1 Aug | 5 1 Aug | 6 1 Aug |
| Field Data Inputs: | | | | | | |
| Barrier in Place (Y or N) | N | N | N | N | N | N |
| Fume Suppressant in Use (Y or N). If Y, then Surf. Tension (dynes/cm) | Y 27.5 | Y 27.5 | Y 27.5 | Y 27.5 | Y 27.5 | Y 27.5 |
| Bath Surface Area (ft ²) | 26.8 | 26.8 | 26.8 | 26.8 | 26.8 | 26.8 |
| Bath Freeboard (inches) | 7.5 | 7.5 | 7.5 | 7.5 | 7.5 | 7.5 |
| Exhaust Intake Area (ft ²) | 2.65 | 2.65 | 2.65 | 2.65 | 2.65 | 2.65 |
| Barometric Pressure (in.Hg) - P _b | 29.97 | 29.97 | 29.97 | 30.05 | 30.05 | 30.05 |
| Stack Diameter (ft.) - D _s | 1.83 | 1.83 | 1.83 | 1.83 | 1.83 | 1.83 |
| S-Pitot Tube Correction (dimensionless) | 0.84 | 0.84 | 0.84 | 0.84 | 0.84 | 0.84 |
| Average Stack Differential Pressure (in. H ₂ O) - Δ P | 0.62 | 0.64 | 0.60 | 0.59 | 0.56 | 0.63 |
| Average of the Square Roots of the Stack Differential Pressure - Δ P ^{0.5} | 0.78 | 0.79 | 0.73 | 0.76 | 0.74 | 0.79 |
| Stack Temperature (EF) - T _s | 82.7 | 88.3 | 91.8 | 82.0 | 86.5 | 89.5 |
| Stack Static Pressure (in.H ₂ O) - P _s | -2.1 | -2.1 | -2.1 | -2.0 | -2.0 | -2.0 |
| Absolute Pressure (in.Hg) - P _a | 29.82 | 29.82 | 29.82 | 29.90 | 29.90 | 29.90 |
| Dry Gas Meter Volume Sampled (ft ³) - V _m | 58.988 | 60.562 | 23.433 | 105.032 | 105.045 | 111.718 |
| Average Dry Gas Meter Temperature (EF) - T _m | 91.0 | 95.7 | 96.7 | 91.5 | 97.5 | 101.0 |
| Dry Gas Meter Cal. Factor (dimensionless) | 0.9922 | 0.9922 | 0.9922 | 0.9922 | 0.9922 | 0.9922 |
| Orifice)H _@ (in.H ₂ O) | 1.7101 | 1.7101 | 1.7101 | 1.7101 | 1.7101 | 1.7101 |
| Average Orifice Diff. Pressure (in.H ₂ O) -)H | 0.76 | 0.78 | 0.14 | 2.25 | 2.12 | 2.38 |
| Water Collected (gm) - V _{lc} | 25.7 | 26.4 | 12.0 | 50.6 | 54.5 | 47.8 |
| Sampling Time (min.) - 2 | 120 | 120 | 120 | 120 | 120 | 120 |
| Nozzle Diameter (inches) - D _n | 0.1875 | 0.1875 | 0.125 | 0.25 | 0.25 | 0.25 |
| Total Impinger + Wash Volume (ml) - V _{tot} | 425 | 395 | 378 | 359 | 366 | 338 |

Table D-14. Tinker AFB - 31 July & 1 Aug 01 (Continued)

| Flow Results: | | | | | | |
|--|-------|--------|--------|--------|--------|--------|
| Average Stack Velocity (ft/sec) - V_s | 44.55 | 45.36 | 42.08 | 43.34 | 42.39 | 45.05 |
| Dry Standard Meter Volume (dscf) - V_{dscf} | 56.26 | 57.28 | 22.09 | 100.72 | 99.61 | 105.35 |
| Moisture in Sample (as a gas, ft ³) - M | 1.21 | 1.24 | 0.56 | 2.38 | 2.56 | 2.25 |
| Moisture in Sample (%) - M_p | 2.10 | 2.12 | 2.49 | 2.31 | 2.51 | 2.09 |
| Dry Molecular Weight - assumed - (lb/lb-mole) - MW_d | 29.00 | 29.00 | 29.00 | 29.00 | 29.00 | 29.00 |
| Wet Molecular Weight (lb/lb-mole) - MW_w | 28.77 | 28.77 | 28.73 | 28.75 | 28.72 | 28.77 |
| Stack Area (ft ²) - A | 2.64 | 2.64 | 2.64 | 2.64 | 2.64 | 2.64 |
| Actual Stack Flow Rate (acfm) - Q_a | 7,060 | 7,180 | 6,660 | 6,860 | 6,710 | 7,140 |
| Standard Stack Flow Rate (scfm) - Q_s | 6,840 | 6,900 | 6,360 | 6,680 | 6,480 | 6,850 |
| Dry Standard Stack Flow (dscfm) - Q_d | 6,700 | 6,750 | 6,200 | 6,530 | 6,320 | 6,710 |
| Isokinetic Rate (% of Isokinetic) - I | 96.23 | 97.24 | 91.88 | 99.41 | 101.56 | 101.18 |
| Laboratory Analysis: | | | | | | |
| Total Chromium Concentration (mg/l) - C_t | 0.410 | 0.0893 | .0657 | 0.215 | 0.265 | 0.231 |
| Hex. Chromium Concentration (mg/l) - C_h | 0.399 | 0.0839 | 0.0557 | 0.192 | 0.242 | 0.214 |
| Percent Hexavalent Chromium (%) | 97.3 | 94.0 | 84.8 | 89.3 | 91.3 | 92.6 |
| Mass of Total Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mt} | 0.174 | 0.0353 | 0.0248 | 0.0772 | 0.0970 | 0.0781 |
| Mass of Hex. Chromium Collected (mg) - (based on impinger + wash volume collected) - C_{mh} | 0.170 | 0.0331 | 0.0211 | 0.0689 | 0.0886 | 0.0723 |

Table D-14. Tinker AFB - 31 July & 1 Aug 01 (Continued)

| Operational Parameters: | | | | | | |
|---|---------|----------|----------|----------|----------|----------|
| Volts – E (avg. of 3 bath sections) | 4.4 | 4.4 | 4.4 | 4.4 | 4.3 | 6.07 |
| Average Amperes – AM (avg. of 3 bath sections) | 136 | 138 | 140 | 149 | 119 | 1,466 |
| Ampere-Hours (Amp-hr) – AH (total of 3 bath sections) | 10,498 | 10,830 | 10,948 | 1,381 | 6,400* | 6,230* |
| Hours Between AH Meter Readings - 2_{AH} | 2.0 | 2.0 | 2.0 | 2.0 | 2.0 | 2.0 |
| Amp-Hr. Normalized to the 2 Hour Test Period - $(AH \times 2/2_{AH})$ | 10,498 | 10,830 | 10,948 | 1,381 | 2,815 | 6,230 |
| Emission Results: | | | | | | |
| Total Chromium Exhaust Concentration (mg/dscf) - C_{st} | 0.00310 | 0.000616 | 0.00112 | 0.000766 | 0.000974 | 0.000741 |
| Hex. Chromium Exhaust Concentration (mg/dscf) - C_{sh} | 0.00301 | 0.000579 | 0.000953 | 0.000684 | 0.000889 | 0.000687 |
| Total Chromium Exhaust Conc. (mg/dscm) - C_{st} | 0.109 | 0.0217 | 0.0397 | 0.0271 | 0.0344 | 0.0262 |
| Hex. Chromium Exhaust Conc. (mg/dscm) - C_{sh} | 0.106 | 0.0204 | 0.0337 | 0.0242 | 0.0314 | 0.0242 |
| Total Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_t | 0.237 | 0.0461 | 0.0764 | 0.435 | 0.116 | 0.0958 |
| Hex. Chromium Emitted/Amp-Hr (mg/Amp-hr) - CAH_h | 0.231 | 0.0433 | 0.0648 | 0.388 | 0.105 | 0.0888 |

* The Amp-hr meter on the first bath circuit (222A) was broken during these two runs. Consequently, 5,000 amp-hrs was assumed for that section for each run, based on prior experience.

APPENDIX E

FORMS AND RELATED DOCUMENTATION USED FOR THE COLLECTION OF FIELD DATA

GLOSSARY OF TERMS

A - Area of Circular Stack (ft^2)
C_p - S-Pitot Tube Correction factor (dimensionless) - assumed to be 0.84
D_n - Diameter of Probe Nozzle (inches)
D_s - Diameter of Stack (inches)
I - Percent of Isokinetic (%)
K_m - Orifice Calibration Constant (dimensionless)
M - Moisture in Gas Sample (as a gaseous volume) (ft^3)
M_p - Percent Moisture in Gas Sample (%)
MW_d - Molecular Weight of Stack Gases - dry (lb/lb-mole or g/g-mole) - assumed to be 29.0
MW_w - Molecular Weight of Stack Gases - moist (lb/lb-mole or g/g-mole)
P_a - Absolute Pressure [$P_b + (P_s/13.6)$] (in.Hg)
P_b - Barometric Pressure (in.Hg)
P_s - Static Pressure in Stack (in.H₂O)
Q_a - Actual Stack Volumetric Flow (acfm)
Q_d - Stack Volumetric Flow at Dry Standard Conditions (dscfm)
Q_m - Dry Gas Meter Volumetric Rate (cfm)
Q_s - Stack Volumetric Flow at Standard Conditions (scfm)
T_m - Average Dry Gas Meter Temperature (EF)
T_s - Stack Temperature (EF)
V_{dscf} - Dry Standard Volume Sampled (dscf)
V_{dscm} - Dry Standard Volume Sampled (dscm) = 2.832×10^{-2} dscf
V_{lc} - Water Collected During Sample Run (grams or ml)
V_m - Dry Gas Meter Volume Sampled (ft^3)
V_n - Velocity of Sampled Gas Inside Probe Nozzle (ft/sec)
V_s - Stack Velocity (ft/sec)
Y - Dry Gas Meter Calibration Factor (dimensionless)

ΔH - Pressure Drop Across Meter Orifice (in.H₂O)
 $\Delta H@$ - ΔH Across Meter Orifice at 0.75 scfm (in.H₂O)
 ΔP - Differential Pressure Across S-Pitot Tube (in.H₂O)
 θ - Sampling Run Time (minutes)

TEST PLAN - METHOD 306 STACK SAMPLING

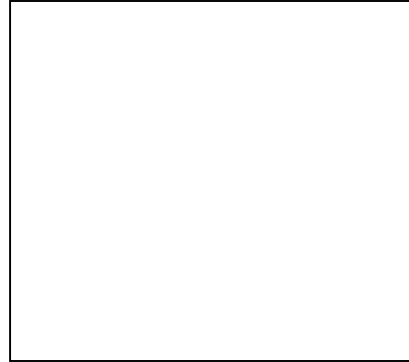
1. At some point check barometric pressure (P_b) with local authorities, and **record**.
2. Drill holes in duct - one on side, one 90E around on bottom.
3. Confirm inside diameter of duct (D_s) (with stick, pipe, etc.).
4. Add 100 ml 0.1N NaOH to first two impingers. **Record** volumes on Water Content data sheet.
5. Add weighed 200 - 300 grams silica gel to last impinger. **Record** weight on Water Content data sheet.
6. Add ice to impinger A cold@ case.
7. Assemble sampling train.
8. **Measure** probe nozzle diameter (D_n), and plug probe w/appropriate stopper.
9. Leak test sampling train at ≥ 15 in.Hg. Must be ≤ 0.02 cfm. **Record** results on Method 306 Field Sampling data sheet.
10. Check manometer(s) to confirm levelness and zero position.
11. Mark probe with tape at appropriate distances for traverse/sampling points.
12. Perform Velocity Traverse (Use Velocity Traverse Data Sheet). Include crude cyclonic flow determination at random points.
13. **Measure** static pressure (P_s) by rotating s-pitot 90E and disconnecting one leg to manometer. Do at 3 or 4 arbitrary points.
14. **Measure** stack temperature (T_s).
15. **Measure** and **record** distance to upstream and downstream disturbances.
16. **Calculate** preliminary stack gas velocity (V_s) using 28.8 as first approximation of molecular weight of stack gases. This is used to confirm correct choice of probe nozzle size.
17. Unplug probe, insert at first traverse point, clamp in place if possible, using carpenter=s square and level.
18. Begin sampling:
 - a) Turn on sampling train (be sure probe tip is unplugged!!).
 - b) **Record** initial dry test meter reading, initial amperes, volts, and ampere hours.
 - c) **Record** time.
 - d) Adjust flow to isokinetic conditions using by-pass valve (monitor and adjust continuously).
 - e) **Record** system vacuum.
 - f) **Record** all parameters (dry gas meter temperatures [T_m], impinger temperature, velocity head ΔP , ΔH across orifice, stack temperature [T_s]) as applicable on Method 306 Field Sampling data sheet.
 - g) After exactly 7-1/2 minutes of operation move probe to next traverse point, and clamp in place
 - h) Repeat steps (b) - (g) until all 8 traverse points on the first axis have been completed.
 - i) Close main valve (or otherwise stop sampling), and move probe to the second axis sampling port. Repeat steps (a) - (h).
19. Turn off sampling train, and remove from duct.
20. **Record** final amperage, voltage, and ampere-hours.

21. Plug probe nozzle and perform leak check. **Record** results on Method 306 Field data sheet.
22. Disassemble sampling train (**CAREFULLY**).
23. Empty impinger with silica gel onto tared balance, and quickly weigh to nearest 0.1 grams. **Record** weight on Water Content data sheet.
24. **Measure** pH of water in first impinger. Should be ≥ 8.5 . If not, repeat pH measurement in second impinger.
25. **Measure** volumes of water in each of impingers 1, 2, and 3 using a graduated cylinder. **Record** volumes on Water Content data sheet. **Calculate** total grams/milliliters collected (V_{lc}). Transfer these volumes to a 1-liter polyethylene sample container. Rinse each of the 3 impingers, probe nozzle, glass probe, and interconnecting glassware and umbilicals into a graduated cylinder with a total of 200 - 300 ml of fresh 0.1N NaOH. **Record** rinsate volume and add to 1-liter polyethylene sample container (which will now contain contents of impingers 1, 2, and 3, plus all rinsate).
26. Filter contents of 1-liter container using 0.45 μm filter assembly (with N_2 pressure). Discard filter paper.
27. Place the 1-liter sample container in iced cooler (or refrigerator) for later shipment to analytical laboratory.
28. Pour about 200 ml of **fresh** 0.1 N NaOH into clean 1-liter polyethylene sample container, and place in cooler for later shipment to laboratory. This will be field blank sample. (Only one necessary per day.)
29. Clean all glassware with: soapy water, then tap water (3 times), then 0.1N NaOH (3 times), then a ≥ 4 hour soak in 1% HNO_3 , then 0.1N NaOH (3 times), then air dry. For the umbilical cord between the probe and the impingers, skip 1% HNO_3 soak. *
30. **Calculate** Dry Standard Meter Volume (V_{dscf}), Moisture Content of Stack Gas (M and M_p), and Wet Stack Gas Molecular Weight (MW_w). Use this MW_w to recalculate Stack Velocity (V_s) for next run.
31. **Calculate** percent Isokinetic (I) to ascertain run validity.

* In most cases glassware were actually cleaned using the following protocol: strong hot alkaline rinse, deionized water rinse, 1% HNO_3 rinse, deionized water rinse, and 0.1 N NaOH rinse.

VELOCITY TRAVERSE

Facility _____
 Date _____
 Sampling Location _____
 Stack Inside Dimension(s) _____
 Barometric Pressure (in.Hg) _____
 Stack Static Pressure (in.H₂O) _____
 Operator _____
 S-Pitot I.D.# _____
 Stack Temperature (EF) _____
 Distance to Upstream Disturbance (inches) _____
 Distance to Downstream Disturbance (inches) _____



Duct/Sampling Point Drawing

| Trav. Point # | Dist. From Sample Pt. (in.) | ΔP (in. H ₂ O) | Cyclon. Flow? | $\Delta P^{0.5}$ |
|------------------|--------------------------------------|---|------------------|------------------|
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| Aver.: | | | | |

| Trav. Point # | Dist. From Sample Pt. (in.) | ΔP (in. H ₂ O) | Cyclon. Flow? | $\Delta P^{0.5}$ |
|------------------|--------------------------------------|---|------------------|------------------|
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |
| Aver.: | | | | |

WATER CONTENT

Facility_____

Sampling Location_____

Date_____

Run Number_____

Operator_____

| Impinger # | Contents | Final Weight (gm) | Initial Weight (gm) | Weight Gain (col.3 - col.4) |
|---|------------|----------------------|------------------------|--------------------------------|
| 1 | 0.1N NaOH | | | |
| 2 | 0.1N NaOH | | | |
| 3 | Empty | | | |
| 4 | Silica Gel | | | |
| TOTAL GRAMS COLLECTED (V _{lc}): | | | | |

Equipment Rinse Volume (ml):

Total Diluted Volume (ml):

METHOD 306 FIELD SAMPLING SHEET

Page__ of__

Facility_____ Ambient Temp. (EF)_____

Location_____ Barometric Pressure.(in.Hg)_____

Operator_____ Assumed Moisture (%)_____

Date_____ Probe Length (inches)_____

Run Number_____ Nozzle I.D._____

Sample Box No._____ Nozzle Diameter (inches)_____

Meter Box No._____ Initial Leak Rate (cfm)_____

Meter $\Delta H@$ _____ Final Leak Rate (cfm)_____

Meter Calib. Factor (Y)_____ Static Pressure (in.H₂O)_____

S-Pitot Coefficient (C_p)_____ $\Delta H = \text{_____} \times \Delta P$



Duct/Sampling Point Drawing

| Traverse Point # | Samp. Time (min.) | System vacuum (in.Hg) | Stack Temp. (EF) - T _s | Veloc. Head (√H ₂ O) - ΔP | ΔP ^{0.5} | Orifice Differ. Press. (√H ₂ O) - ΔH | Dry Gas Meter Reading (ft ³) - V _m | Temperature at Dry Gas Meter | | Temp.@ Last Imping. (EF) |
|------------------|-------------------|-----------------------|-----------------------------------|--------------------------------------|-------------------|---|---|------------------------------|-------------|--------------------------|
| | | | | | | | | Inlet (EF) | Outlet (EF) | |
| Initial Read. | 0 | N/A | N/A | N/A | N/A | N/A | | N/A | N/A | N/A |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| Totals | | | | | | | | | | |
| Avg | | | | | | | | T _m : | | |

STACK VELOCITY (ft/sec) - V_s

$$V_s = 85.49 \times C_p \times \Delta P^{0.5} \times [(T_s + 460)/(MW_w \times P_a)]^{0.5}$$

$$V_s = 85.49 \times C_p \times \Delta P^{0.5} \times [(T_s + 460)/(28.8 \times P_a)]^{0.5}$$

$$V_s = 85.49 \times () \times ()^{0.5} \times [(() + 460)/(28.8 \times ())]^{0.5}$$

$$V_s = \text{_____} \text{ ft/sec}$$

* Assume for first approximation that MW_w is 28.8 (assumes 2% water by volume)

DRY STANDARD METER VOLUME (ft³) - V_{dscf}

$$V_{dscf} = V_m \times Y \times [(528/29.92) \times (P_b + (\Delta H/13.6))]/(T_m + 460)$$

$$V_{dscf} = () \times () \times [17.64 \times (() + (()/13.6))]/[() + 460]$$

$$V_{dscf} = \text{_____} \text{ dscf}$$

MOISTURE CONTENT OF STACK GAS (as a gas) (ft³) - M

$$M = 8.94 \times 10^{-5} \text{ ft}^3/\text{gram} \times \text{Standard Temperature} \times V_{lc}$$

$$M = 8.94 \times 10^{-5} \times 528 \times V_{lc}$$

$$M = 0.047 \times ()$$

$$M = \text{_____} \text{ ft}^3$$

MOISTURE CONTENT OF STACK GAS (as a gas) (%) - M_p

$$M_p = 100 \times M / (M + V_{\text{dscf}})$$

$$M_p = 100 \times (\quad) / [(\quad) + (\quad)]$$

$$M_p = \text{_____} \%$$

WET GAS MOLECULAR WEIGHT (lb/lb-mole) - MW_w

(Assume $MW_d = 29.0$ per Method 2, section 3.6)

$$MW_w = [29.0 \times (1 - (M_p/100))] + (18 \times M_p/100)$$

$$MW_w = [29.0 \times (1 - ((\quad)/100))] + [0.18 \times (\quad)]$$

$$MW_w = \text{_____} \text{ lb/lb-mole (or g/g-mole)}$$

AREA OF CIRCULAR STACK (ft²) - A

$$A = D_s^2 \times 5.454 \times 10^{-3}$$

$$A = (\quad)^2 \times 5.454 \times 10^{-3}$$

$$A = \text{_____} \text{ ft}^2$$

ACTUAL STACK VOLUMETRIC FLOW RATE (acfm) - Q_a

$$Q_a = V_s \times A \times 60$$

$$Q_a = (\quad) \times (\quad) \times 60$$

$$Q_a = \text{_____} \text{ acfm}$$

STANDARD STACK VOLUMETRIC RATE (scfm) - Q_s

$$Q_s = Q_a \times (528/29.92) \times [P_a/(T_s + 460)]$$

$$Q_s = (\quad) \times 17.65 \times [(\quad) / ((\quad) + 460)]$$

$$Q_s = \underline{\hspace{2cm}} \text{ scfm}$$

DRY STANDARD STACK VOLUMETRIC RATE (dscfm) - Q_d

$$Q_d = Q_s \times (1 - (M_p/100))$$

$$Q_d = (\quad) \times [1 - ((\quad) / 100)]$$

$$Q_d = \underline{\hspace{2cm}} \text{ dscfm}$$

ISOKINETIC DETERMINATION (%) - I

$$I = \frac{100 \times (T_s + 460) \times [\{ 2.669 \times 10^{-3} \times V_{lc} \} + \{ [(V_m \times Y)/(T_m + 460)] \times (P_b + (\Delta H/13.6)) \}]}{60 \times \theta \times V_s \times P_a \times (D_n^2 \times 5.45 \times 10^{-3})}$$

$$I = \frac{100 \times ((\quad) + 460) \times [\{ 2.669 \times 10^{-3} \times (\quad) \} + \{ [((\quad) \times (\quad)) / ((\quad) + 460)] \times ((\quad) + ((\quad) / 13.6)) \}]}{0.327 \times (\quad) \times (\quad) \times (\quad) \times (\quad)^2}$$

$$I = \underline{\hspace{2cm}} \%$$

ΔH VERSUS ΔP RELATIONSHIP FOR QUICK ISOKINETIC ADJUSTMENT

$$\Delta H = \{846.72 \times D_n^4 \times \Delta H_{@} \times C_p^2 \times (1 - (M_p/100))^2 \times (MW_d/MW_w) \times ((460 + T_m)/(460 + T_s)) \times (P_a/(P_b + \Delta H/13.6))\} \times \Delta P$$

If $C_p = 0.84$, then:

$$\Delta H = \{597.45 \times D_n^4 \times \Delta H_{@} \times (1 - (M_p/100))^2 \times (MW_d/MW_w) \times ((460 + T_m)/(460 + T_s)) \times (P_a/(P_b + \Delta H/13.6))\} \times \Delta P$$

If $M_p = 2.0\%$, $MW_d = 29.0$, and $MW_w = 28.8$, then:

$$\Delta H = \{589.56 \times D_n^4 \times \Delta H_{@} \times (460 + T_m)/(460 + T_s) \times (P_a/(P_b + \Delta H/13.6))\} \times \Delta P$$

$D_n =$

$D_n^4 =$

$M_p =$

$(1 - (M_p/100))^2 =$

$\Delta H_{@} =$

$MW_w =$

$MW_d/MW_w =$

$T_m =$

$T_s =$

$+ T_s) =$

$(460 + T_m)/(460$

$P_b =$

$P_s =$

$(P_s/13.6)) =$

$P_a = (P_b +$

$\Delta H_{(assumed)} =$

$(P_b + (\Delta H_{(assumed)}/13.6)) =$

$(assumed)/13.6)\} =$

$P_a/\{P_b + (\Delta H$

$$\Delta H = (\quad) \times \Delta P$$

| | | | | | | | | | | | | | | |
|---|----------|------------------------------|------------|-----------|---------------|------------|-----------------------------|-------------|--------------|--------------|-----------|---|---|--|
| To: Fax: | | | | | From: POC: | | | | | Phone: | | | | |
| INDUSTRIAL | | | | | | | | | | | | | | |
| HYGIENE SINGLE STRESSOR AIR SAMPLE SURVEY FORM | | | | | | | | | | | | | | |
| IH UIC: _____ Activity: _____ UIC: _____ | | | | | | | | | | | | | | |
| Building/Location: _____ Shop/Code: _____ Date: _____ | | | | | | | | | | | | | | |
| Fax: Product Used: _____ | | | | | | | | | | | | | | |
| Ventilation: _____ Meets Specs: _____ Used: _____ | | | | | | | | | | | | | | |
| Exposure during the unsampled period is: Same as the sampled period Zero Other _____ | | | | | | | | | | | | | | |
| Shift: | 1. Day | Frequency of Operation | 1. Daily | 2. 2-3/wk | 3. Weekly | 4. 2-3/mo | Duration of Operation | 1. 0-15 min | 2. 15-30 min | 3. 30-60 min | 4. 1-2 hr | | | |
| 2. Eve. | 3. Night | | 5. Monthly | 6. 2-3/yr | 7. Yearly | 8. Special | | 5. 2-4 hr | 6. 4-6 hr | 7. 6-8 hr | 8. >8 hr | | | |
| M or C P or A | | | M | C | 1 | P | A | | M | C | 2 | P | A | |
| | | | M | C | 3 | P | A | | M | C | 4 | P | A | |
| Employee Name: | | | | | | | | | | | | | | |
| SSN/Badge # | | | | | | | | | | | | | | |
| Task | | | | | | | | | | | | | | |
| Worksite | | | | | | | | | | | | | | |
| Job Title | | | | | | | | | | | | | | |
| Operation | | | | | | | | | | | | | | |
| Code | | | | | | | | | | | | | | |
| Respirator | | | | | | | | | | | | | | |
| Code | | | | | | | | | | | | | | |
| PPE | | | | | | | | | | | | | | |
| Code(s) | | | | | | | | | | | | | | |
| Stressor | | | | | | | | | | | | | | |
| CAS # | | | | | | | | | | | | | | |
| Sample # | | | | | | | | | | | | | | |
| Laboratory # | | | | | | | | | | | | | | |
| Sample Duration | | | | | | | | | | | | | | |
| Flow Rate | | | | | | | | | | | | | | |
| Volume (minutes) | | | | | | | | | | | | | | |
| Results (liters per minute) | | | | | | | | | | | | | | |
| Concentration (liters) | | | | | | | | | | | | | | |
| 8-hr TWA | | | | | | | | | | | | | | |
| Date Received: _____ Analytical Method: _____ LOD: _____ | | | | | | | | | | Comments: | | | | |
| Analysis Performed By: _____ Date Analyzed: _____ | | | | | | | | | | | | | | |
| Analysis Reviewed By: _____ Date Reported: _____ | | | | | | | | | | | | | | |

| | | | | | |
|--|-------|---------|------------|--|----------------|
| Calibrator: | (Mfg) | (Model) | (Serial #) | | Pre Cal Date: |
| <div style="border-bottom: 1px solid black; height: 15px; width: 100%;"></div> | | | | | |
| Calibrated By: | | | | | Post Cal Date: |
| <div style="border-bottom: 1px solid black; height: 15px; width: 100%;"></div> | | | | | |

| | 1 | 2 | 3 | 4 | 5 |
|--------------------|---|---|---|---|---|
| Pump Mfg | | | | | |
| Pump Model | | | | | |
| Pump Type | | | | | |
| Pump Serial # | | | | | |
| Pre Cal Flow Rate | | | | | |
| Post Cal Flow rate | | | | | |
| Lower Flow Rate | | | | | |
| Field ID # | | | | | |
| Media | | | | | |
| Lot/Tube # | | | | | |
| Expiration Date | | | | | |
| Time Off | | | | | |
| Time On | | | | | |
| Pump Check(s) | | | | | |

| | |
|----------------------------|-----------------------|
| IHT/WPM: _____ Date: _____ | IH: _____ Date: _____ |
|----------------------------|-----------------------|

PRIVACY ACT STATEMENT: The Privacy Act of 1974 requires that federal agencies inform individuals about certain facts they are requested to provide for inclusion into government records, such as this industrial hygiene record. These records, as appropriate, may be furnished to agencies of the Federal, State, or local government for legal, regulatory or administrative purposes. Disclosure of the requested information is voluntary, however, if not provided, acceptance of the submitted record may be denied.

| | | | | |
|--------------------|--------------------|--------------------|--------------------|--------------------|
| _____ Signature | _____ Signature | _____ Signature | _____ Signature | _____ Signature |
| _____ Date | _____ Date | _____ Date | _____ Date | _____ Date |

Sample Chain of Custody Form for Stack Emission Samples

| FY00 Test Coupon Matrix Log | | Sample Logging Matrix NAVAIR Patuxent River Laboratory | | |
|-----------------------------------|----|--|----------------|------------|
| Matrix Number | | Project Name | Originator | Date |
| 0 | 1 | Trivalent Chromium Pretreatment Application and Test | Craig Matzdorf | 10/13/1999 |
| 0 | 2 | TCP10M Application and Test | Craig Matzdorf | 11/22/1999 |
| 0 | 3 | TCP10 Paint Adhesion Validation | Craig Matzdorf | 12/14/1999 |
| 0 | 4 | TCP10M Spray Corrosion Performance Validation | Craig Matzdorf | 3/2/2000 |
| 0 | 5 | TCP10 Surface Tension Evaluation | Craig Matzdorf | 1/5/2000 |
| 0 | 6 | TCP Surface Tension(Painted) Evaluation | Craig Matzdorf | 3/7/2000 |
| 0 | 7 | TCP Timing/Use Evaluation | Craig Matzdorf | 7/6/2000 |
| 0 | 8 | F-18 (Painted) Corrosion Test | Craig Matzdorf | 6-15-2000 |
| 0 | 9 | | | |
| 0 | 10 | | | |
| 0 | 11 | | | |
| 0 | 12 | | | |
| 0 | 13 | | | |
| 0 | 14 | | | |
| 0 | 15 | | | |
| 0 | 16 | | | |
| 0 | 17 | | | |
| 0 | 18 | | | |
| 0 | 19 | | | |
| 0 | 20 | | | |

| SAMPLE Tracking Record for NAVAIR Patuxent River Laboratory | | | | | | | | | | | | | |
|--|-----|-----------|-------|--------|--------|-----------------|---------|-----|-----------|-----------|--------|--------|-----------------|
| FY00 Matrix 03 | | | | | | | | | | | | | |
| TCP10 Paint Adhesion Validation (Note: This is not the WA/FS test) | | | | | | | | | | | | | |
| 7075-T6 | | | | | | | 2024-T3 | | | | | | |
| Panel | SPT | 2337 7 | 85582 | 85582N | Test | Pretreat | Panel | SPT | 2337 7 | 8558 2 | 85582N | Test | Pretreat |
| 7-1 | X | | | | 1D WTA | Accelagold-S | 2-1 | X | | | | 1D WTA | Accelagold-S |
| 7-2 | X | | | | 4D WTA | Accelagold-S | 2-2 | X | | | | 4D WTA | Accelagold-S |
| 7-3 | X | | | | 7D WTA | Accelagold-S | 2-3 | X | | | | 7D WTA | Accelagold-S |
| 7-4 | | X | | | 1D WTA | Accelagold-S | 2-4 | | X | | | 1D WTA | Accelagold-S |
| 7-5 | | X | | | 4D WTA | Accelagold-S | 2-5 | | X | | | 4D WTA | Accelagold-S |
| 7-6 | | X | | | 7D WTA | Accelagold-S | 2-6 | | X | | | 7D WTA | Accelagold-S |
| 7-7 | | | X | | 1D WTA | Accelagold-S | 2-7 | | | X | | 1D WTA | Accelagold-S |
| 7-8 | | | X | | 4D WTA | Accelagold-S | 2-8 | | | X | | 4D WTA | Accelagold-S |
| 7-9 | | | X | | 7D WTA | Accelagold-S | 2-9 | | | X | | 7D WTA | Accelagold-S |
| 7-10 | | | | X | 1D WTA | Accelagold-S | 2-10 | | | | X | 1D WTA | Accelagold-S |
| 7-11 | | | | X | 4D WTA | Accelagold-S | 2-11 | | | | X | 4D WTA | Accelagold-S |
| 7-12 | | | | X | 7D WTA | Accelagold-S | 2-12 | | | | X | 7D WTA | Accelagold-S |
| 7-13 | X | | | | 1D WTA | Alodine 1200S-W | 2-13 | X | | | | 1D WTA | Alodine 1200S-W |
| 7-14 | X | | | | 4D WTA | Alodine 1200S-W | 2-14 | X | | | | 4D WTA | Alodine 1200S-W |
| 7-15 | X | | | | 7D WTA | Alodine 1200S-W | 2-15 | X | | | | 7D WTA | Alodine 1200S-W |
| 7-16 | | X | | | 1D WTA | Alodine 1200S-W | 2-16 | | X | | | 1D WTA | Alodine 1200S-W |
| 7-17 | | X | | | 4D WTA | Alodine 1200S-W | 2-17 | | X | | | 4D WTA | Alodine 1200S-W |
| 7-18 | | X | | | 7D WTA | Alodine 1200S-W | 2-18 | | X | | | 7D WTA | Alodine 1200S-W |
| 7-19 | | | X | | 1D WTA | Alodine 1200S-W | 2-19 | | | X | | 1D WTA | Alodine 1200S-W |
| 7-20 | | | X | | 4D WTA | Alodine 1200S-W | 2-20 | | | X | | 4D WTA | Alodine 1200S-W |
| 7-21 | | | X | | 7D WTA | Alodine 1200S-W | 2-21 | | | X | | 7D WTA | Alodine 1200S-W |
| 7-22 | | | | X | 1D WTA | Alodine 1200S-W | 2-22 | | | | X | 1D WTA | Alodine 1200S-W |
| 7-23 | | | | X | 4D WTA | Alodine 1200S-W | 2-23 | | | | X | 4D WTA | Alodine 1200S-W |
| 7-24 | | | | X | 7D WTA | Alodine 1200S-W | 2-24 | | | | X | 7D WTA | Alodine 1200S-W |
| 7-25 | X | | | | 1D WTA | Alodine 1200S-I | 2-25 | X | | | | 1D WTA | Alodine 1200S-I |
| 7-26 | X | | | | 4D WTA | Alodine 1200S-I | 2-26 | X | | | | 4D WTA | Alodine 1200S-I |
| 7-27 | X | | | | 7D WTA | Alodine 1200S-I | 2-27 | X | | | | 7D WTA | Alodine 1200S-I |
| 7-28 | | X | | | 1D WTA | Alodine 1200S-I | 2-28 | | X | | | 1D WTA | Alodine 1200S-I |
| 7-29 | | X | | | 4D WTA | Alodine 1200S-I | 2-29 | | X | | | 4D WTA | Alodine 1200S-I |
| 7-30 | | X | | | 7D WTA | Alodine 1200S-I | 2-30 | | X | | | 7D WTA | Alodine 1200S-I |
| 7-31 | | | X | | 1D WTA | Alodine 1200S-I | 2-31 | | | X | | 1D WTA | Alodine 1200S-I |
| 7-32 | | | X | | 4D WTA | Alodine 1200S-I | 2-32 | | | X | | 4D WTA | Alodine 1200S-I |
| 7-33 | | | X | | 7D WTA | Alodine 1200S-I | 2-33 | | | X | | 7D WTA | Alodine 1200S-I |
| 7-34 | | | | X | 1D WTA | Alodine 1200S-I | 2-34 | | | | X | 1D WTA | Alodine 1200S-I |
| 7-35 | | | | X | 4D WTA | Alodine 1200S-I | 2-35 | | | | X | 4D WTA | Alodine 1200S-I |
| | | | | | | | | | | | | | |

SAMPLE MATERIALS LAB REPORT #TR-YYMMDD-PROG-B-ABC-1*

Prepared By:

Prepared For (Customer):

Location: Inorganic Coatings Laboratory, Aerospace Materials Division, Patuxent River, MD

Purpose:

Issues:

Test Method and Sampling Procedures:

Subcontracted Efforts:

Environmental Conditions:

Conclusion and Results:

Lab Manager Approval & Date:

*** # is derived from below:**

YYMMDD = Date of Report (e.g.: 990129 for 29 Jan 1999)

PROG = Program (If Applicable. If not, omit)

B = Branch (0 for 434, 1 for 4341, 2 for 4342, & 3 for 4343)

ABC = Individuals Initials

1 = sequential # of related report

APPENDIX F

FATIGUE TEST METHODOLOGY

and

SPECIMEN SPECIFICATIONS

**A Comparison of Chrome Plating Processes on the Axial Fatigue
Behavior of Aermet 100, 300M, and 13-8PH Steels**

NAVAIR
Naval Air Warfare Center – Aircraft Division
Aerospace Materials Division
Metals, Ceramics & NDE Branch
Patuxent River, Maryland 20670

March 27, 2003

Customer

Craig Matzdorf
Materials Engineer
NAWC-AD, Code 4.3.4.1
Building 2188, M/S 5
48066 Shaw Road
Patuxent River, Maryland 20670
Phone: 301-342-9372
E-mail: matzdorc@navair.navy.mil

Project Engineer

Michael J. Leap
Materials Engineer & Technical Manager
Mechanical Properties Laboratory
NAWC-AD, Code 4.3.4.2
Building 2188, M/S 5
48066 Shaw Road
Patuxent River, Maryland 20670
Phone: 301-342-8022
Facsimile: 301-342-8024
E-mail: leapmj@navair.navy.mil


Michael J. Leap

Work Performed by:

J. Bilko
H. C. Sanders
R. E. Taylor

Investigation MT1089
(Distribution Limited to Codes 4.3.4.1 and 4.3.4.2)

Summary

Axial fatigue tests were conducted to evaluate the effects of chrome plating processes on the fatigue resistance of Aermet 100, 300M, and 13-8PH steels. Uncoated specimens, which provide a baseline measure of fatigue resistance for each material, are compared to specimens chrome plated with a standard process and specimens chrome plated with a fume suppressant. The high cycle fatigue behavior of each material was evaluated at stress ratios of -1 and 0.1 with a 30 Hz sinusoidal loading waveform while the low cycle fatigue behavior was evaluated at strain ratios of -1 and 0.1 with a 0.4 Hz triangular loading waveform. The customer specified the maximum stress and strain values for the different steels and stress/strain ratios.

Conclusions

1. Uncoated specimens of the three steels qualitatively exhibit better fatigue resistance than specimens chrome plated with either a standard process or a process employing a fume suppressant.
2. Specimens chrome plated with a process that employs a fume suppressant exhibit longer fatigue lives than specimens chrome plated with a standard process for a majority of the steels and test conditions. **However, since a very limited number of specimens were tested for each material and test condition, statistical comparisons between data sets should only be treated as rough qualitative indications of the effects of chrome plating process on fatigue life.**

Background

The test program was initiated to evaluate the effects of utilizing a fume suppressant during chrome plating on the fatigue behavior of plated Aermet 100, 300M, and 13-8PH steel specimens subjected to different load ratios and loading severities. The customer supplied uncoated specimens, specimens plated with a standard process, and specimens plated with a process that incorporates a fume suppressant. The customer also specified the loading parameters for each series of tests and, subsequent to testing, verbally requested a statistical analysis of the fatigue life data.

The purpose of this report is to document the results of the testing program and provide a summary of the fatigue life data.

Procedure

Axial fatigue test parameters for the three steels are summarized in Table 1. The tests were conducted on straight-gaged specimens with a 0.25 in. diameter and a 0.75 in. gage length. High cycle fatigue (HCF) tests were conducted at stress ratios of -1 and 0.1 on servo-hydraulic test systems operating in load control with a 30 Hz sinusoidal loading waveform. Run-out is defined as specimen survival at 10^7 cycles for the HCF tests. Low cycle fatigue (LCF) tests were conducted at strain ratios of -1 and 0.1 on servohydraulic test systems operating in strain control with a 0.4 Hz triangular loading waveform. Strain control during LCF testing was achieved with a 0.5 in. extensometer mounted over the center of each specimen. LCF specimens that survived 10^4 cycles were removed from test.

Based on a request by the customer, a statistical analysis of the fatigue life data for each steel and loading history was conducted using a commercial software package.¹ Fatigue life data were evaluated in terms of both normal and Weibull distributions with a maximum likelihood estimation procedure. LCF specimens that survived 10^4 cycles and specimens that failed outside the gage section were treated as suspended tests in the analysis.

Results and Discussion

Fatigue data for the Aermet 100, 300M, and 13-8PH steels are tabulated in Appendix A, B, and C, respectively. A summary of statistical parameters for normal distribution and Weibull distribution representations of the fatigue data is provided in Tables 2-4 and Tables 5-7, respectively. With the exception of Aermet 100 specimens tested at 110 ksi and $R = -1$, the selected stress levels for HCF tests on uncoated specimens are less than or very near the endurance limit, σ_{END} , for all combinations of material and stress ratio. The strain levels selected for the LCF tests also are lower than the strains corresponding to a fatigue limit of 10^4 cycles, ϵ_{FL} , in four of six combinations of material and strain ratio. Thus, quantitative comparisons of the degradation in the LCF and HCF life of the steels resulting from either chrome plating process are not possible in a majority of cases, although these data qualitatively suggest that the fatigue life of the uncoated specimens is greater than the fatigue life of specimens plated with either process when tested at equivalent conditions. Consistent with this observation, the fatigue lives of chrome plated specimens are significantly less than the fatigue life of the corre-

¹Weibull++, version 6 - Trademark of ReliaSoft Corporation.

sponding uncoated specimens for the three conditions in which the uncoated specimens exhibit finite life, Tables 2 and 3.

Fatigue life comparisons for specimens chrome plated with a standard process and a process employing a fume suppressant are summarized in Table 8. The data for both normal distribution and Weibull distribution representations of the fatigue data suggest that the fatigue life of specimens chrome plated with a fume suppressant is greater than the fatigue life of specimens chrome plated with a standard process for the 300M steel, 13-8PH stainless steel, and HCF specimens of the Aermet 100 steel. Conversely, Aermet 100 specimens plated with the two processes exhibit similar LCF fatigue lives.

While a majority of these data indicate significant differences in fatigue life, it must be recognized that the statistical basis for each data set is not sufficient to provide reliable quantitative estimates of the distribution parameters for each material and testing condition. Therefore, the distribution parameters, Tables 2-7, and the statistical comparisons, Table 8, should only be treated as rough indicators of fatigue life and differences in fatigue life. A great deal more data (i.e., 15-20 specimens per condition) obviously would be required to provide reliable estimates of the distribution parameters for each material and testing condition.

Table 1: Summary of Axial Fatigue Test Paramaters

| MATERIAL | HIGH CYCLE FATIGUE TESTS | | | | LOW CYCLE FATIGUE TESTS | | | |
|------------------------|--------------------------|----------------------|---------------------|--------------------------|-------------------------|----------------|---------------------|--------------------------|
| | STRESS RATIO, R | MAXIMUM STRESS (ksi) | TEST FREQUENCY (Hz) | APPLIED LOADING WAVEFORM | STRAIN RATIO, R | MAXIMUM STRAIN | TEST FREQUENCY (Hz) | APPLIED LOADING WAVEFORM |
| AERMET 100 STEEL | -1 | 110 | 30 | SINUSOIDAL | -1 | 0.0066 | 0.4 | TRIANGULAR |
| | 0.1 | 160 | 30 | SINUSOIDAL | 0.1 | 0.0140 | 0.4 | TRIANGULAR |
| | | | | | | | | |
| 300M STEEL | -1 | 95 | 30 | SINUSOIDAL | -1 | 0.0057 | 0.4 | TRIANGULAR |
| | 0.1 | 135 | 30 | SINUSOIDAL | 0.1 | 0.0110 | 0.4 | TRIANGULAR |
| | | | | | | | | |
| 13-8PH STAINLESS STEEL | -1 | 85 | 30 | SINUSOIDAL | -1 | 0.0054 | 0.4 | TRIANGULAR |
| | 0.1 | 150 | 30 | SINUSOIDAL | 0.1 | 0.0080 | 0.4 | TRIANGULAR |

Table 2: Normal Distribution Parameters for Aermet 100 Steel

| COATING CONDITION | TEST TYPE (LCF OR HCF) | STRESS OR STRAIN RATIO, R | NUMBER OF SPECIMENS | STATISTICAL BASIS | FATIGUE LIFE, MEAN \pm STD. DEVIATION (CYCLES) | LOWER/UPPER 95% CONFIDENCE LIMITS (CYCLES) | LOWER/UPPER 99% CONFIDENCE LIMITS (CYCLES) | COMMENTS |
|--|------------------------------|------------------------------------|------------------------|----------------------|--|--|--|---|
| UNCOATED | HCF | -1 | 8 | 3 | 5452500 \pm 4750500 | 7508700/1015 4000 | .../11631000 | 1 INVALID TEST, 1 SUSPENDED TEST, AND 3 RUN-OUTS. |
| | HCF | 0.1 | 5 | ... | $\sigma \approx \sigma_{END}$ (REFER TO REPORT) | ... | ... | 4 RUN-OUTS AND 1 SPECIMEN FAILURE AT 432088 CYCLES. |
| EXTRA HARD CHROME | HCF | -1 | 4 | 4 | 13066 \pm 1186 | 11903/14228 | 11538/14593 | |
| | HCF | 0.1 | 4 | 3 | 8583 \pm 288 | 8257/8909 | 8155/9012 | 1 TEST (N = 44090 CYCLES) TREATED AS AN OUTLIER. |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | HCF | -1 | 4 | 4 | 17468 \pm 374 | 17101/17834 | 16986/17949 | |
| | HCF | 0.1 | 4 | 2 | 10937 \pm 96 | 10817/11057 | 10779/11095 | 2 SUSPENDED TESTS. |
| | | | | | | | | |
| UNCOATED | LCF | -1 | 6 | ... | $\epsilon \leq \epsilon_{FL}$ (REFER TO REPORT) | ... | ... | 5 SUSPENDED TESTS AND 1 SPECIMEN FAILURE AT 8728 CYCLES (INVALID TEST). |
| | LCF | 0.1 | 4 | 4 | 5818 \pm 1043 | 4795/6840 | 4474/7161 | |
| EXTRA HARD CHROME | LCF | -1 | 4 | 2 | 3981 \pm 1724 | 1865/6097 | 1200/6762 | 2 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | 4 | 2582 \pm 636 | 1958/3206 | 1762/3402 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | LCF | -1 | 4 | 2 | ... | ... | ... | 2 SUSPENDED TESTS. NO CONVERGENCE OF DATA TO A SOLUTION. |
| | LCF | 0.1 | 4 | 4 | 2569 \pm 387 | 2189/2949 | 2070/3068 | |

Table 3: Normal Distribution Parameters for 300M Steel

| COATING CONDITION | TEST TYPE (LCF OR HCF) | STRESS OR STRAIN RATIO, R | NUMBE R OF SPECIM ENS | STATIS TICAL BASIS | FATIGUE LIFE, MEAN \pm STD. DEVIATION (CYCLES) | LOWER/UPPER 95% CONFIDENCE LIMITS (CYCLES) | LOWER/UPPER 99% CONFIDENCE LIMITS (CYCLES) | COMMENTS |
|--|------------------------------|------------------------------------|--------------------------------|--------------------------|--|--|--|---|
| UNCOATED | HCF | -1 | 5 | ... | $\sigma \approx \sigma_{\text{END}}$ (REFER TO REPORT) | ... | ... | 4 RUN-OUTS AND 1 SPECIMEN FAILURE AT 215087 CYCLES. |
| | HCF | 0.1 | 4 | ... | $\sigma \leq \sigma_{\text{END}}$ (REFER TO REPORT) | ... | ... | 4 RUN-OUTS. |
| EXTRA HARD CHROME | HCF | -1 | 4 | 4 | 24556 \pm 847 | 23725/25386 | 23464/25647 | |
| | HCF | 0.1 | 4 | 4 | 18410 \pm 3180 | 15294/21527 | 14314/22506 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | HCF | -1 | 5 | 4 | 26028 \pm 704 | 25374/26682 | 25169/26887 | 1 SUSPENDED TEST. |
| | HCF | 0.1 | 3 | 3 | 20260 \pm 1593 | 18457/22063 | 17891/22629 | |
| | | | | | | | | |
| UNCOATED | LCF | -1 | 4 | ... | $\epsilon \leq \epsilon_{\text{FL}}$ (REFER TO REPORT) | ... | ... | 4 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | 3 | 7987 \pm 1156 | 6678/9296 | 6267/9707 | DATA RECORD FOR ONE SPECIMEN LOST. |
| EXTRA HARD CHROME | LCF | -1 | 4 | 4 | 3055 \pm 1193 | 1885/4225 | 1518/4593 | |
| | LCF | 0.1 | 5 | 4 | 3018 \pm 327 | 2698/3338 | 2598/3439 | 1 SUSPENDED TEST. |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | LCF | -1 | 4 | 4 | 5284 \pm 2141 | 3185/7383 | 2526/8042 | |
| | LCF | 0.1 | 4 | 4 | 3876 \pm 438 | 3446/4306 | 3311/4441 | |

Table 4: Normal Distribution Parameters for 13-8PH Stainless Steel

| COATING CONDITION | TEST TYPE (LCF OR HCF) | STRESS OR STRAIN RATIO, R | NUMBER OF SPECIMENS | STATISTICAL BASIS | FATIGUE LIFE, MEAN \pm STD. DEVIATION (CYCLES) | LOWER/UPPER 95% CONFIDENCE LIMITS (CYCLES) | LOWER/UPPER 99% CONFIDENCE LIMITS (CYCLES) | COMMENTS |
|--|------------------------------|------------------------------------|------------------------|----------------------|--|--|---|-----------------------|
| UNCOATED | HCF | -1 | 4 | ... | $\sigma \leq \sigma_{END}$ (REFER TO REPORT) | ... | ... | 4 RUN-OUTS. |
| | HCF | 0.1 | 4 | ... | $\sigma \leq \sigma_{END}$ (REFER TO REPORT) | ... | ... | 4 RUN-OUTS. |
| EXTRA HARD CHROME | HCF | -1 | 4 | 4 | 38036 \pm 2293 | 35789/40284 | 35082/40990 | |
| | HCF | 0.1 | 4 | 4 | 16644 \pm 1613 | 15063/18225 | 14567/18721 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | HCF | -1 | 4 | 4 | 60184 \pm 3007 | 57237/63132 | 56311/64058 | |
| | HCF | 0.1 | 4 | 4 | 22071 \pm 2075 | 20038/24105 | 19399/24744 | |
| | | | | | | | | |
| UNCOATED | LCF | -1 | 4 | ... | $\varepsilon \leq \varepsilon_{FL}$ (REFER TO REPORT) | ... | ... | 4 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | ... | $\varepsilon \leq \varepsilon_{FL}$ (REFER TO REPORT) | ... | ... | 4 SUSPENDED TESTS. |
| EXTRA HARD CHROME | LCF | -1 | 5 | 3 | 8724 \pm 1707 | 7022/10427 | 6487/10962 | 2 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | 4 | 6711 \pm 2974 | 3796/9626 | 2880/10542 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | LCF | -1 | 4 | ... | ... | ... | ... | 4 INVALID TESTS. |
| | LCF | 0.1 | 4 | 2 | 9846 \pm 774 | 8947/10745 | 8664/11028 | 2 SUSPENDED TESTS. |

Table 5: Weibull Distribution Parameters for Aermet 100 Steel

| COATING CONDITION | TEST TYPE (LCF OR HCF) | STRESS OR STRAIN RATIO, R | NUMBER OF SPECI- MENS | STATISTI- CAL BASIS | MEDIAN FATIGUE LIFE, L_{50} (CYCLES) | CHARACTERI- STIC FATIGUE LIFE, L_c (CYCLES) | WEIBULL SLOPE, m | LOWER/UPPER 95% CONFIDENCE LIMITS (CYCLES) | COMMENTS |
|--|---------------------------------|---------------------------------------|--------------------------------|---------------------------|--|---|---------------------|--|---|
| UNCOATED | HCF | -1 | 8 | 3 | 4550800 | 7406600 | 0.75 | 994610/20822000 | 1 INVALID TEST, 1 SUSPENDED TEST, AND 3 RUN-OUTS. |
| | HCF | 0.1 | 5 | ... | $\sigma \approx \sigma_{END}$ (REFER TO REPORT) | ... | ... | ... | 4 RUN-OUTS AND 1 SPECIMEN FAILURE AT 432088 CYCLES. |
| EXTRA HARD CHROME | HCF | -1 | 4 | 4 | 13205 | 13545 | 14.4 | 12182/14313 | |
| | HCF | 0.1 | 4 | 3 | ... | ... | m > 20 | ... | 1 TEST (N = 44090 CYCLES) TREATED AS AN OUTLIER. WEIBULL DISTRIBUTION NOT APPROPRIATE FOR DATA SET. |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | HCF | -1 | 4 | 4 | ... | ... | m > 20 | ... | WEIBULL DISTRIBUTION NOT APPROPRIATE FOR DATA SET (m > 20). |
| | HCF | 0.1 | 4 | 2 | ... | ... | m > 20 | ... | 2 SUSPENDED TESTS. WEIBULL DISTRIBUTION NOT APPROPRIATE FOR DATA SET (m > 20). |
| | | | | | | | | | |
| UNCOATED | LCF | -1 | 6 | ... | $\varepsilon \leq \varepsilon_{FL}$ (REFER TO REPORT) | ... | ... | ... | 5 SUSPENDED TESTS AND 1 SPECIMEN FAILURE AT 8728 CYCLES (INVALID TEST). |
| | LCF | 0.1 | 4 | 4 | 5939 | 6177 | 9.32 | 5251/6716 | |
| EXTRA HARD CHROME | LCF | -1 | 4 | 2 | 3922 | 4574 | 2.38 | 2191/7020 | 2 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | 4 | 2619 | 2807 | 5.27 | 2101/3263 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | LCF | -1 | 4 | 2 | 3953 | 4073 | 12.2 | 3468/4505 | 2 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | 4 | 2612 | 2710 | 9.89 | 2324/2935 | |

Table 6: Weibull Distribution Parameters for 300M Steel

| COATING CONDITION | TEST TYPE (LCF OR HCF) | STRESS OR STRAIN RATIO, R | NUMBER OF SPECIMENS | STATISTICAL BASIS | MEDIAN FATIGUE LIFE, L_{50} (CYCLES) | CHARACTERISTIC FATIGUE LIFE, L_c (CYCLES) | WEIBULL SLOPE, m | LOWER/UPPER 95% CONFIDENCE LIMITS (CYCLES) | COMMENTS |
|--|---------------------------------|---------------------------------------|---------------------------|----------------------|---|--|---------------------|--|--|
| UNCOATED | HCF | -1 | 5 | ... | $\sigma \approx \sigma_{END}$ (REFER TO REPORT) | ... | ... | ... | 4 RUN-OUTS AND 1 SPECIMEN FAILURE AT 215087 CYCLES. |
| | HCF | 0.1 | 4 | ... | $\sigma \leq \sigma_{END}$ (REFER TO REPORT) | ... | ... | ... | 4 RUN-OUTS. |
| EXTRA HARD CHROME | HCF | -1 | 4 | 4 | ... | ... | m > 20 | ... | WEIBULL DISTRIBUTION NOT APPROPRIATE FOR DATA SET (m > 20). |
| | HCF | 0.1 | 4 | 4 | 18807 | 19495 | 10.2 | 16811/21040 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | HCF | -1 | 5 | 4 | ... | ... | m > 20 | ... | 1 SUSPENDED TEST. WEIBULL DISTRIBUTION NOT APPROPRIATE FOR DATA SET (m > 20). |
| | HCF | 0.1 | 3 | 3 | 20437 | 20887 | 16.8 | 18870/22134 | |
| | | | | | | | | | |
| UNCOATED | LCF | -1 | 4 | ... | $\varepsilon \leq \varepsilon_{FL}$ (REFER TO REPORT) | ... | ... | ... | 4 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | 3 | 8124 | 8390 | 11.4 | 7222/9138 | DATA RECORD FOR ONE SPECIMEN LOST. |
| EXTRA HARD CHROME | LCF | -1 | 4 | 4 | 3071 | 3422 | 3.39 | 2177/4333 | |
| | LCF | 0.1 | 5 | 4 | 3056 | 3169 | 10.1 | 2728/3425 | 1 SUSPENDED TEST. |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | LCF | -1 | 4 | 4 | 5244 | 5930 | 2.98 | 3551/7745 | |
| | LCF | 0.1 | 4 | 4 | 3919 | 4053 | 10.9 | 3524/4359 | |

Table 7: Weibull Distribution Parameters for 13-8PH Stainless Steel

| COATING CONDITION | TEST TYPE (LCF OR HCF) | STRES S OR STRAIN RATIO, R | NUMBER OF SPECIM ENS | STATISTI CAL BASIS | MEDIAN FATIGUE LIFE, L_{50} (CYCLES) | CHARACTERI STIC FATIGUE LIFE, L_c (CYCLES) | WEIBULL SLOPE, m | LOWER/UPPER 95% CONFIDENCE LIMITS (CYCLES) | COMMENTS |
|--|---------------------------------|---|-------------------------------|--------------------------|---|--|---------------------|--|---|
| UNCOATED | HCF | -1 | 4 | ... | $\sigma \leq \sigma_{END}$ (REFER TO REPORT) | ... | ... | ... | 4 RUN-OUTS. |
| | HCF | 0.1 | 4 | ... | $\sigma \leq \sigma_{END}$ (REFER TO REPORT) | ... | ... | ... | 4 RUN-OUTS. |
| EXTRA HARD CHROME | HCF | -1 | 4 | 4 | 38274 | 39043 | 18.4 | 35936/40765 | |
| | HCF | 0.1 | 4 | 4 | 16849 | 17286 | 14.3 | 15531/18279 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | HCF | -1 | 4 | 4 | ... | ... | m > 20 | ... | WEIBULL DISTRIBUTION NOT APPROPRIATE FOR DATA SET (m > 20). |
| | HCF | 0.1 | 4 | 4 | 22253 | 22959 | 11.7 | 20151/24573 | |
| | | | | | | | | | |
| UNCOATED | LCF | -1 | 4 | ... | $\epsilon \leq \epsilon_{FL}$ (REFER TO REPORT) | ... | ... | ... | 4 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | ... | $\epsilon \leq \epsilon_{FL}$ (REFER TO REPORT) | ... | ... | ... | 4 SUSPENDED TESTS. |
| EXTRA HARD CHROME | LCF | -1 | 5 | 3 | 8817 | 9399 | 5.74 | 7223/10764 | 2 SUSPENDED TESTS. |
| | LCF | 0.1 | 4 | 4 | 6678 | 7499 | 3.16 | 4654/9584 | |
| EXTRA HARD CHROME WITH FUME SUPPRESSANT | LCF | -1 | 4 | ... | ... | ... | ... | ... | 4 INVALID TESTS. |
| | LCF | 0.1 | 4 | 2 | 9854 | 10056 | 18.1 | 9123/10644 | 2 SUSPENDED TESTS. |

Table 8: Summary of Statistical Comparisons

| MATERIAL | CONDITION 1 | CONDITION 2 | TEST TYPE (LCF OR HCF) | NORMAL DISTRIBUTION REPRESENTATION OF DATA | | WEIBULL DISTRIBUTION REPRESENTATION OF DATA | |
|------------------------------|-------------|-----------------|---------------------------|---|---|--|---|
| | | | | COMPARISON OF MEAN LIVES | PROBABILITY OF DIFFERENCE IN MEAN LIVES | COMPARISON OF MEDIAN LIVES | PROBABILITY OF DIFFERENCE IN MEDIAN LIVES |
| AERMET 100 STEEL | EHC R = -1 | EHC/WFS R = -1 | HCF | CONDITION 1 < CONDITION 2 | >0.99 | NO COMPARISON POSSIBLE | |
| | EHC R = 0.1 | EHC/WFS R = 0.1 | HCF | CONDITION 1 < CONDITION 2 | >0.99 | NO COMPARISON POSSIBLE | |
| AERMET 100 STEEL | EHC R = -1 | EHC/WFS R = -1 | LCF | NO COMPARISON POSSIBLE | | CONDITION 1 < CONDITION 2 | 0.50 |
| | EHC R = 0.1 | EHC/WFS R = 0.1 | LCF | CONDITION 1 > CONDITION 2 | 0.51 | CONDITION 1 > CONDITION 2 | 0.52 |
| 300M STEEL | EHC R = -1 | EHC/WFS R = -1 | HCF | CONDITION 1 < CONDITION 2 | 0.91 | NO COMPARISON POSSIBLE | |
| | EHC R = 0.1 | EHC/WFS R = 0.1 | HCF | CONDITION 1 < CONDITION 2 | 0.70 | CONDITION 1 < CONDITION 2 | 0.74 |
| 300M STEEL | EHC R = -1 | EHC/WFS R = -1 | LCF | CONDITION 1 < CONDITION 2 | 0.82 | CONDITION 1 < CONDITION 2 | 0.84 |
| | EHC R = 0.1 | EHC/WFS R = 0.1 | LCF | CONDITION 1 < CONDITION 2 | 0.94 | CONDITION 1 < CONDITION 2 | 0.93 |
| 13-8PH STAINLESS STEEL | EHC R = -1 | EHC/WFS R = -1 | HCF | CONDITION 1 < CONDITION 2 | >0.99 | NO COMPARISON POSSIBLE | |
| | EHC R = 0.1 | EHC/WFS R = 0.1 | HCF | CONDITION 1 < CONDITION 2 | 0.98 | CONDITION 1 < CONDITION 2 | 0.97 |
| 13-8PH STAINLESS STEEL | EHC R = -1 | EHC/WFS R = -1 | LCF | NO COMPARISON POSSIBLE | | NO COMPARISON POSSIBLE | |
| | EHC R = 0.1 | EHC/WFS R = 0.1 | LCF | CONDITION 1 < CONDITION 2 | 0.85 | CONDITION 1 < CONDITION 2 | 0.89 |

Appendix A- Part 2

Axial Fatigue Data for Aermet 100 Steel

Appendix A(a) Aermet 100 Low-Cycle Fatigue

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089
Test Completion Date: 02-Aug-01

Total Number of Specimens: 6

Material Description: Aermet 100

| TEST MACHINE: IRWIN | | Settings: | | | Specimen: | | | |
|--|--------------|---|--------------------|---------------|---|------------------|--------|--|
| Load Cell S/N: 1870 Extensometer S/N: 367 | | Load Cell Range: 10 kips Extensometer Range: 0.010 Alignment Method: MTS EZALIGN Test Rate: 0.4 Hz | | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | |
| TEST RESULTS | | | | | | | | |
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in.) | Initial Area (in²) | Strain (in./in.) | Cycles | Remarks |
| 100A-1 | -1 | RT | 0.75 | 0.2500 | 0.04908 | 0.0066 | 10,001 | Suspended test |
| 100A-4 | -1 | RT | 0.75 | 0.2500 | 0.04908 | 0.0066 | 10,001 | Suspended test |
| 100A-2 | -1 | RT | 0.75 | 0.2500 | 0.04908 | 0.0066 | 8,728 | Knife edges moved (invalid test) |
| 100A-3 | -1 | RT | 0.75 | 0.2500 | 0.04908 | 0.0066 | 10,001 | Suspended test |
| 100A-25 | -1 | RT | 0.75 | 0.2500 | 0.04908 | 0.0066 | 20,002 | Suspended test |
| 100A-26 | -1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0066 | 10,000 | Suspended test Tested on Interlaken with Ext. 1322547 |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Robert E. Taylor (signature on file)

Date: 03-Jan-02

Test Completion Date: 16-Dec-01

Total Number of Specimens: 4

TEST MACHINE: INTERLAKEN

Specimen:

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in

Alignment Method: MTS EZALIGN
Test Rate: 0.4 Hz

| TEST RESULTS | | | | | | | | |
|--------------|--------------|----------|--------------------|------------------|---------------------------------|------------------|--------|-----------------|
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in. n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
| 100A-13 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0140 | 4,295 | Broke in center |
| 100A-14 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0140 | 6,085 | Broke in center |
| 100A-15 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0140 | 6,655 | Broke in center |
| 100A-16 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0140 | 6,235 | Broke in center |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 14-Mar-02

Total Number of Specimens: 4

Material Description: Aernmet 100 chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | Settings: | Specimen: | | | | | |
|---|--------------|--|---|----------------|---------------------------------|------------------|--------|---|
| Load Cell S/N: 50071 Extensometer S/N: 1322547 | | Load Cell Range: 25 kips Extensometer Range: 0.030 Alignment Method: Dial indicator Test Rate: 0.4 Hz | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | | |
| TEST RESULTS | | | | | | | | |
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
| 100A-5 | -1 | RT | 0.75 | 0.2550 | 0.05107 | 0.0066 | 2,151 | Broke at top radius outside gage length |
| 100A-6 | -1 | RT | 0.75 | 0.2550 | 0.05107 | 0.0066 | 4,029 | Broke at top radius outside gage length |
| 100A-7 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0066 | 4,627 | Broke in gage length |
| 100A-8 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0066 | 1,471 | Broke at top of gage length |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 14-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 21-Mar-02

Total Number of Specimens: 4

Material Description: Aermet 100 chrome plated (EHC)

TEST MACHINE: INTERLAKEN

Settings:

Specimen:

Load Cell S/N: 50071
Extensometer S/N: 1322547

Load Cell Range: 25 kips
Extensometer Range: 0.030

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

Alignment Method: Dial indicator
Test Rate: 0.4 Hz

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|------------------|--------|--------------------------------|
| 100A-17 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 0.0140 | 3,357 | Crack in center of gage length |
| 100A-34 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0140 | 2,333 | Broke in center of gage length |
| 100A-19 | 0.1 | RT | 0.75 | 0.2560 | 0.05147 | 0.0140 | 1,864 | Broke in center of gage length |
| 100A-20 | 0.1 | RT | 0.75 | 0.2535 | 0.05047 | 0.0140 | 2,774 | Crack in center of gage length |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 27-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: Aermet 100 chrome plated with fume suppressant (EHC/WFS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: 1322547
Load Cell Range: 25 kips
Extensometer Range: 0.030
Alignment Method: Dial indicator
Test Rate: 0.4 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|------------------|--------|---------------------------------|
| 100A-9 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 0.0066 | 4,280 | Specimen failed in center |
| 100A-10 | -1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0066 | 2,764 | Specimen failed in upper radius |
| 100A-11 | -1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0066 | 2,746 | Specimen failed in lower radius |
| 100A-12 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 0.0066 | 3,495 | Specimen failed in center |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Total Number of Specimens: 4

Test Completion Date: 12-Feb-03

Material Description: Aermet 100 chrome plated with fume suppressant (EHC/WFS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: 1322547

Load Cell Range: 25 kips
Extensometer Range: 0.030
Alignment Method: Dial indicator
Test Rate: 0.4 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|------------------|--------|---|
| 100A-21 | 0.1 | RT | 0.75 | 0.2530 | 0.05027 | 0.0140 | 2,036 | Specimen failed in center |
| 100A-22 | 0.1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0140 | 2,590 | Specimen failed in center |
| 100A-23 | 0.1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0140 | 2,694 | Specimen failed in center |
| 100A-24 | 0.1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0140 | 2,956 | Specimen failed in lower center of gage section |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

Appendix A (b)- Aermet 100 High-Cycle Fatigue

Test Completion Date: 02-Dec-01

Laboratory Report: MT1089
Total Number of Specimens: 8

Material Description: Aermet 100

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: N/A
Load Cell Range: 25 kips
Extensometer Range: N/A
Alignment Method: MTS EZALIGN
Test Rate: 30 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

| TEST RESULTS | | | | | | | | | |
|--------------|--------------|----------|--------------------|----------------|---------------------------------|--------------|------------|------------|--|
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(in .) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 100B-25 | -1 | RT | 0.75 | 0.2505 | 0.04928 | 140 | 6902.5 | 5,500,000 | Broke, wrong stress level applied (invalid test) |
| 100B-1 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 110 | 5530.0 | 3,286,010 | Broke in upper grip |
| 100B-3 | -1 | RT | 0.75 | 0.2510 | 0.04948 | 110 | 5442.9 | 10,000,000 | Run-out |
| 100B-2 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 110 | 5486.8 | 1,728,823 | Broke in center |
| 100B-4 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 110 | 5486.8 | 1,789,894 | Broke in center |
| 100B-26 | -1 | RT | 0.75 | 0.2510 | 0.04948 | 110 | 5442.9 | 10,000,000 | Run-out |
| 100B-27 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 110 | 5486.8 | 269,927 | Broke in center |
| 100B-32 | -1 | RT | 0.75 | 0.2510 | 0.04948 | 110 | 5442.8 | 10,000,000 | Run-out |

COMMENTS: High cycle fatigue – Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 02-Dec-01

Total Number of Specimens: 5

Material Description: Aermet 100

| TEST MACHINE: INTERLAKEN | | | Settings: | | Specimen: | | | | |
|---|--------------|----------|---|---------------|---|--------------|------------|------------|-----------------|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | | Load Cell Range: 25 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | |
| | | | Alignment Method: MTS EZALIGN Test Rate: 30 Hz | | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(in.) | Initial Area (in²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 100B-13 | 0.1 | RT | 0.75 | 0.2520 | 0.04985 | 160 | 7976.0 | 10,000,000 | Run-out |
| 100B-14 | 0.1 | RT | 0.75 | 0.2515 | 0.04968 | 160 | 7948.8 | 432,088 | Broke in center |
| 100B-15 | 0.1 | RT | 0.75 | 0.2520 | 0.04985 | 160 | 7976.0 | 10,000,000 | Run-out |
| 100B-16 | 0.1 | RT | 0.75 | 0.2520 | 0.04985 | 160 | 7976.0 | 10,000,000 | Run-out |
| 100B-31 | 0.1 | RT | 0.75 | 0.2515 | 0.04968 | 160 | 7948.8 | 10,000,000 | Run-out |

COMMENTS: High cycle fatigue – Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Total Number of Specimens: 4

Test Completion Date: 14-Mar-02

Material Description: Aermet 100 chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | | | Settings: | | Specimen: | | | | |
|--|--|--------------|----------|---|----------------|---|--------------|------------|--------|----------------------|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | | | Load Cell Range: 25 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | |
| Alignment Method: Dial indicator Test Rate: 30 Hz | | | | | | | | | | |
| TEST RESULTS | | | | | | | | | | |
| Specimen ID | | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 100B-28 | | -1 | RT | 0.75 | 0.2565 | 0.05167 | 110 | 5683.7 | 14,437 | Broke in gage length |
| 100B-6 | | -1 | RT | 0.75 | 0.2580 | 0.05228 | 110 | 5750.8 | 13,603 | Broke in gage length |
| 100B-7 | | -1 | RT | 0.75 | 0.2600 | 0.05309 | 110 | 5840.0 | 11,776 | Broke in gage length |
| 100B-8 | | -1 | RT | 0.75 | 0.2590 | 0.05269 | 110 | 5795.9 | 12,446 | Broke in gage length |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 14-Mar-02

Total Number of Specimens: 4

Material Description: Aernmet 100 chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | Settings: | Specimen: | | | | | | |
|---|--------------|---|---|----------------|---------------------------------|--------------|------------|--------|----------------------|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | Load Cell Range: 25 kips Extensometer Range: N/A Alignment Method: Dial indicator Test Rate: 30 Hz | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 100B-17 | 0.1 | RT | 0.75 | 0.2580 | 0.05228 | 160 | 8364.8 | 8,617 | Broke in gage length |
| 100B-18 | 0.1 | RT | 0.75 | 0.2580 | 0.05228 | 160 | 8364.8 | 8,853 | Broke in gage length |
| 100B-34 | 0.1 | RT | 0.75 | 0.2575 | 0.05208 | 160 | 8332.8 | 8,280 | Broke in gage length |
| 100B-20 | 0.1 | RT | 0.75 | 0.2580 | 0.05228 | 160 | 8364.8 | 44,090 | Broke in gage length |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: Aermet 100 chrome plated with fume suppressant (EHC/FS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: N/A
Load Cell Range: 25 kips
Extensometer Range: N/A
Alignment Method: Dial indicator
Test Rate: 30 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|--------------|------------|--------|--|
| 100B-9 | -1 | RT | 0.75 | 0.2560 | 0.05147 | 110 | 5661.7 | 17,518 | Failed in center |
| 100B-10 | -1 | RT | 0.75 | 0.2550 | 0.05107 | 110 | 5617.7 | 17,168 | Failed in center |
| 100B-11 | -1 | RT | 0.75 | 0.2555 | 0.05127 | 110 | 5639.7 | 17,977 | Failed in bottom center inside gage length |
| 100B-12 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 110 | 5595.7 | 17,207 | Failed in center |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: Aermet 100 chrome plated with fume suppressant (EHC/FS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: N/A
Load Cell Range: 25 kips
Extensometer Range: N/A
Alignment Method: Dial indicator
Test Rate: 30 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|--------------|------------|--------|---|
| 100B-21 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 160 | 8171.2 | 10,658 | Failed in upper center outside gage length |
| 100B-22 | 0.1 | RT | 0.75 | 0.2560 | 0.05147 | 160 | 8235.2 | 11,000 | Failed in center |
| 100B-23 | 0.1 | RT | 0.75 | 0.2560 | 0.05147 | 160 | 8235.2 | 10,811 | Failed in upper center inside gage length |
| 100B-24 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 160 | 8203.2 | 10,914 | Failed in bottom center outside gage length |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

Appendix B - Axial Fatigue Data for 300M Steel

Appendix B (a) - 300M Low-Cycle Fatigue

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089
Test Completion Date: 19-Mar-02

Total Number of Specimens: 4

Material Description: 300M chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | Settings: | Specimen: |
|--------------------------|---------------------------|--|---|
| Load Cell S/N: 50071 | Extensometer S/N: 1322547 | Load Cell Range: 25 kips Extensometer Range: 0.030 Alignment Method: Dial indicator Test Rate: 0.4 Hz | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. |

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|-----------------|---------------------------------|------------------|--------|----------------------|
| 300A-5 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0057 | 4,264 | Broke in gage length |
| 300A-6 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0057 | 2,078 | Broke in gage length |
| 300A-7 | -1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0057 | 3,896 | Broke in gage length |
| 300A-8 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0057 | 1,983 | Broke in gage length |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089 **Test Completion Date:** 25-Mar-02

Total Number of Specimens: 5

Material Description: 300M chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | Settings: | Specimen: | | | | | |
|---|--------------|--|---|----------------|---------------------------------|------------------|--------|--------------------------------|
| Load Cell S/N: 50071 Extensometer S/N: 1322547 | | Load Cell Range: 25 kips Extensometer Range: 0.030 Alignment Method: Dial indicator Test Rate: 0.4 Hz | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | | |
| TEST RESULTS | | | | | | | | |
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
| 300A-17 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 0.0110 | 3,115 | Broke in center of gage length |
| 300A-18 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0110 | 2,862 | Broke in center of gage length |
| 300A-19 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 0.0110 | 2,605 | Broke in center of gage length |
| 300A-20 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0110 | 1,916 | Broke in lower radius |
| 300A-36 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0110 | 3,490 | Broke in center of gage length |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file) **Date:** 27-Mar-02

Test Completion Date: 19-Mar-02

Total Number of Specimens: 4

TEST MACHINE: INTERLAKEN

Specimen:

Load Cell Range: 25 kips
Extensometer Range: 0.030

Alignment Method: Dial indicator

Test Rate: 0.4 Hz

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in. n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|------------------|---------------------------------|------------------|--------|----------------------|
| 300A-5 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0057 | 4,264 | Broke in gage length |
| 300A-6 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0057 | 2,078 | Broke in gage length |
| 300A-7 | -1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0057 | 3,896 | Broke in gage length |
| 300A-8 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0057 | 1,983 | Broke in gage length |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 25-Mar-02

Total Number of Specimens: 5

Material Description: 300M chrome plated (EHC)

TEST MACHINE: INTERLAKEN

Settings:

Specimen:

Load Cell S/N: 50071
Extensometer S/N: 1322547

Load Cell Range: 25 kips
Extensometer Range: 0.030

Alignment Method: Dial indicator

Test Rate: 0.4 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|-----------------|---------------------------------|------------------|--------|--------------------------------|
| 300A-17 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 0.0110 | 3,115 | Broke in center of gage length |
| 300A-18 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0110 | 2,862 | Broke in center of gage length |
| 300A-19 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 0.0110 | 2,605 | Broke in center of gage length |
| 300A-20 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0110 | 1,916 | Broke in lower radius |
| 300A-36 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0110 | 3,490 | Broke in center of gage length |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 27-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: 300M chrome plated with fume suppressant (EHC/WFS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: 1322547

Load Cell Range: 25 kips
Extensometer Range: 0.030

Alignment Method: Dial indicator
Test Rate: 0.4 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|------------------|--------|--|
| 300A-9 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 0.0057 | 8,480 | Specimen failed in center |
| 300A-10 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 0.0057 | 4,040 | Specimen failed in bottom center of gage section |
| 300A-11 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 0.0057 | 4,100 | Specimen failed in center |
| 300A-12 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 0.0057 | 4,515 | Specimen failed in center |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: 300M chrome plated with fume suppressant (EHC/WFS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
 Extensometer S/N: 1322547

Load Cell Range: 25 kips
 Extensometer Range: 0.030

Alignment Method: Dial indicator
 Test Rate: 0.4 Hz

Geometry: 0.25 in. diameter
 Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|------------------|--------|--|
| 300A-21 | 0.1 | RT | 0.75 | 0.2525 | 0.05007 | 0.0110 | 3,956 | Specimen failed in center |
| 300A-22 | 0.1 | RT | 0.75 | 0.2525 | 0.05007 | 0.0110 | 3,405 | Specimen failed in center |
| 300A-23 | 0.1 | RT | 0.75 | 0.2525 | 0.05007 | 0.0110 | 3,703 | Specimen failed in center |
| 300A-24 | 0.1 | RT | 0.75 | 0.2515 | 0.04968 | 0.0110 | 4,440 | Specimen failed above and below center in gage section |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

Appendix B (b) – 300M High Cycle Fatigue

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Total Number of Specimens: 5

Test Completion Date: 02-Dec-01

Material Description: 300M

| TEST MACHINE: INTERLAKEN | | | | Settings: | | Specimen: | | | |
|---|--------------|----------|--------------------|---|---------------------------------|---|------------|------------|-----------------|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | | | Load Cell Range: 25 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | |
| | | | | Alignment Method: MTS EZALIGN Test Rate: 30 Hz | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 300B-2 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 95 | 4775.6 | 215,087 | Broke in center |
| 300B-1 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 95 | 4775.6 | 10,000,000 | Run-out |
| 300B-3 | -1 | RT | 0.75 | 0.2520 | 0.04985 | 95 | 4735.8 | 10,000,000 | Run-out |
| 300B-4 | -1 | RT | 0.75 | 0.2525 | 0.05005 | 95 | 4754.6 | 10,000,000 | Run-out |
| 300B-25 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 95 | 4775.6 | 10,000,000 | Run-out |
| | | | | | | | | | |

COMMENTS: High cycle fatigue – Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 02-Dec-01

Total Number of Specimens: 4

Material Description: 300M

| TEST MACHINE: INTERLAKEN | | | Settings: | | Specimen: | | | | |
|---|--------------|----------|---|------------------|---|--------------|------------|------------|---------|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | | Load Cell Range: 25 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | |
| | | | Alignment Method: MTS EZALIGN Test Rate: 30 Hz | | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(in. n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 300B-13 | 0.1 | RT | 0.75 | 0.2520 | 0.04985 | 135 | 6729.8 | 10,000,000 | Run-out |
| 300B-14 | 0.1 | RT | 0.75 | 0.2525 | 0.05005 | 135 | 6756.5 | 10,000,000 | Run-out |
| 300B-15 | 0.1 | RT | 0.75 | 0.2520 | 0.04985 | 135 | 6729.8 | 10,000,000 | Run-out |
| 300B-16 | 0.1 | RT | 0.75 | 0.2520 | 0.04985 | 135 | 6729.8 | 10,000,000 | Run-out |

COMMENTS: High cycle fatigue – Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089 Test Completion Date: 12-Mar-02

Total Number of Specimens: 4

Material Description: 300M chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | | | Settings: | | Specimen: | | | |
|---|--------------|----------|--------------------|--|---------------------------------|---|------------|--------|----------------------|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | | | Load Cell Range: 25 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | |
| | | | | Alignment Method: Dial indicator Test Rate: 30 Hz | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 300B-5 | -1 | RT | 0.75 | 0.2590 | 0.05269 | 95 | 5005.6 | 25,755 | Broke in gage length |
| 300B-6 | -1 | RT | 0.75 | 0.2590 | 0.05269 | 95 | 5005.6 | 24,437 | Broke in gage length |
| 300B-7 | -1 | RT | 0.75 | 0.2585 | 0.05248 | 95 | 4985.6 | 24,255 | Broke in gage length |
| 300B-8 | -1 | RT | 0.75 | 0.2590 | 0.05269 | 95 | 5005.6 | 23,775 | Broke in gage length |
| | | | | | | | | | |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file) Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 14-Mar-02

Total Number of Specimens: 4

Material Description: 300M chrome plated (EHC)

TEST MACHINE: 20 KIP MTS (RM 206C)

Settings:

Specimen:

Load Cell S/N: 815
Extensometer S/N: N/A

Load Cell Range: 10 kips
Extensometer Range: N/A

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

Alignment Method: Dial indicator

Test Rate: 30 Hz

TEST RESULTS

| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|--------------|------------|--------|----------------------|
| 300B-17 | 0.1 | RT | 0.75 | 0.2600 | 0.05309 | 135 | 7168.0 | 20,192 | Broke in gage length |
| 300B-18 | 0.1 | RT | 0.75 | 0.2585 | 0.05248 | 135 | 7085.0 | 13,705 | Broke in gage length |
| 300B-19 | 0.1 | RT | 0.75 | 0.2590 | 0.05269 | 135 | 7113.0 | 20,482 | Broke in gage length |
| 300B-20 | 0.1 | RT | 0.75 | 0.2610 | 0.05350 | 135 | 7223.0 | 19,262 | Broke in gage length |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Robert E. Taylor (signature on file)

Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 5

Material Description: 300M chrome plated with fume suppressant (EHC/FS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: N/A
Load Cell Range: 25 kips
Extensometer Range: N/A
Alignment Method: Dial indicator
Test Rate: 30 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|--------------|------------|--------|--|
| 300B-9 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 95 | 4832.7 | 25,154 | Failed in center |
| 300B-10 | -1 | RT | 0.75 | 0.2550 | 0.05107 | 95 | 4851.7 | 26,204 | Failed in upper center inside gage length |
| 300B-11 | -1 | RT | 0.75 | 0.2555 | 0.05127 | 95 | 4870.7 | 25,392 | Failed in upper center inside gage length |
| 300B-12 | -1 | RT | 0.75 | 0.2560 | 0.05147 | 95 | 4889.7 | 25,723 | Failed in upper center outside gage length |
| 300B-21 | -1 | RT | 0.75 | 0.2555 | 0.05127 | 95 | 4870.7 | 26,978 | Failed in center |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 3

Material Description: 300M chrome plated with fume suppressant (EHC/FS)

| TEST MACHINE: INTERLAKEN | | | | Settings: | | Specimen: | | | |
|---|--------------|----------|--------------------|--|---------------------------------|---|------------|--------|---|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | | | Load Cell Range: 25 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | |
| | | | | Alignment Method: Dial indicator Test Rate: 30 Hz | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 300B-22 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 135 | 6894.5 | 18,829 | Failed in center |
| 300B-23 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 135 | 6894.5 | 19,975 | Failed in lower center inside gage length |
| 300B-24 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 135 | 6894.5 | 21,976 | Failed in center |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

Appendix C - Axial Fatigue Data for 13-8PH Steel

Appendix C (a)- 13-8PH Low-Cycle Fatigue

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 16-Dec-01

Total Number of Specimens: 4

Material Description: 13-8PH

| TEST MACHINE: INTERLAKEN | | | Settings: | | Specimen: | | | |
|---|--------------|----------|---|---------------|---|------------------|--------|----------------|
| Load Cell S/N: 50071 Extensometer S/N: 1322547 | | | Load Cell Range: 25 kips Extensometer Range: 0.030 | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | |
| | | | Alignment Method: MTS EZALIGN Test Rate: 0.4 Hz | | | | | |
| TEST RESULTS | | | | | | | | |
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
| 13-8A-1 | -1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0054 | 10,000 | Suspended test |
| 13-8A-2 | -1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0054 | 10,000 | Suspended test |
| 13-8A-3 | -1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0054 | 10,000 | Suspended test |
| 13-8A-4 | -1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0054 | 10,000 | Suspended test |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 16-Dec-01

Total Number of Specimens: 4

Material Description: 13-8PH

| TEST MACHINE: INTERLAKEN | | | Settings: | | Specimen: | | | |
|---|--------------|----------|---|---------------|---|------------------|--------|----------------|
| Load Cell S/N: 50071 Extensometer S/N: 1322547 | | | Load Cell Range: 25 kips Extensometer Range: 0.030 | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | |
| | | | Alignment Method: MTS EZALIGN Test Rate: 0.4 Hz | | | | | |
| TEST RESULTS | | | | | | | | |
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
| 13-8A-13 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0080 | 10,000 | Suspended test |
| 13-8A-14 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0080 | 10,000 | Suspended test |
| 13-8A-15 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0080 | 10,000 | Suspended test |
| 13-8A-16 | 0.1 | RT | 0.75 | 0.2490 | 0.04870 | 0.0080 | 10,000 | Suspended test |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 21-Mar-02

Total Number of Specimens: 5

Material Description: 13-8PH chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | | Settings: | | Specimen: | | | |
|---|--------------|----------|---|----------------|---|------------------|--------|--|
| Load Cell S/N: 50071 Extensometer S/N: 1322547 | | | Load Cell Range: 25 kips Extensometer Range: 0.030 | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | |
| | | | Alignment Method: Dial indicator | | | | | |
| | | | Test Rate: 0.4 Hz | | | | | |
| TEST RESULTS | | | | | | | | |
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
| 13-8A-30 | -1 | RT | 0.75 | 0.2540 | 0.05067 | 0.0054 | 6,640 | Broke at top of gage length |
| 13-8A-5 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0054 | 7,284 | Broke at bottom of gage length |
| 13-8A-6 | -1 | RT | 0.75 | 0.2560 | 0.05147 | 0.0054 | 9,233 | Broke at center of gage length |
| 13-8A-7 | -1 | RT | 0.75 | 0.2535 | 0.05047 | 0.0054 | 7,630 | Broke at bottom radius outside gage length |
| 13-8A-8 | -1 | RT | 0.75 | 0.2555 | 0.05127 | 0.0054 | 10,000 | Suspended test |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 21-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 22-Mar-02

Total Number of Specimens: 4

Material Description: 13-8PH chrome plated (EHC)

| TEST MACHINE: INTERLAKEN | | Settings: | Specimen: | | | | | |
|---|--------------|--|---|---------------|---------------------------------|------------------|--------|---------------------------------|
| Load Cell S/N: 50071 Extensometer S/N: 1322547 | | Load Cell Range: 25 kips Extensometer Range: 0.030 Alignment Method: Dial indicator Test Rate: 0.4 Hz | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | | |
| TEST RESULTS | | | | | | | | |
| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter(in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
| 13-8A-17 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 0.0080 | 8,250 | Crack in center of gage section |
| 13-8A-18 | 0.1 | RT | 0.75 | 0.2545 | 0.05087 | 0.0080 | 2,250 | Crack in center of gage section |
| 13-8A-19 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 0.0080 | 8,200 | Crack in center of gage section |
| 13-8A-20 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 0.0080 | 8,144 | Crack in center of gage section |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 27-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: 13-8PH chrome plated with fume suppressant (EHC/WFS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: 1322547

Load Cell Range: 25 kips
Extensometer Range: 0.030

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

Alignment Method: Dial indicator
Test Rate: 0.4 Hz

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|------------------|--------|--|
| 13-8A-9 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 0.0054 | 9,716 | Specimen failed on top, outside gage length - cracks in center |
| 13-8A-10 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 0.0054 | 6,585 | Specimen failed on bottom, outside gage length |
| 13-8A-11 | -1 | RT | 0.75 | 0.2520 | 0.04988 | 0.0054 | 9,401 | Specimen failed on top, outside gage length - cracks in center |
| 13-8A-12 | -1 | RT | 0.75 | 0.2505 | 0.04928 | 0.0054 | 8,170 | Specimen failed on top, outside gage length - cracks in gage |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: 13-8PH chrome plated with fume suppressant (EHC/WFS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: 1322547

Load Cell Range: 25 kips
Extensometer Range: 0.030

Alignment Method: Dial indicator
Test Rate: 0.4 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Strain Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Strain (in./in.) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|------------------|--------|---|
| 13-8A-21 | 0.1 | RT | 0.75 | 0.2505 | 0.04928 | 0.0080 | 8,800 | Specimen failed in center |
| 13-8A-22 | 0.1 | RT | 0.75 | 0.2510 | 0.04948 | 0.0080 | 10,000 | Suspended test |
| 13-8A-23 | 0.1 | RT | 0.75 | 0.2520 | 0.04988 | 0.0080 | 9,616 | Specimen failed on top, outside gage length |
| 13-8A-24 | 0.1 | RT | 0.75 | 0.2525 | 0.05007 | 0.0080 | 9,741 | Specimen failed top of center, inside gage length |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

COMMENTS: Low cycle fatigue – Tests without failures suspended at 10,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

Appendix C (b)- 13-8PH High-Cycle Fatigue

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Test Completion Date: 02-Dec-01

Laboratory Report: MT1089

Total Number of Specimens: 4

Material Description: 13-8PH

| TEST MACHINE: INTERLAKEN | | | Settings: | | Specimen: | | | | |
|---|--------------|----------|---|----------------|---|--------------|------------|------------|---------|
| Load Cell S/N: 50071 Extensometer S/N: N/A | | | Load Cell Range: 25 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | |
| | | | Alignment Method: MTS EZALIGN Test Rate: 30 Hz | | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 13-8B-1 | -1 | RT | 0.75 | 0.2525 | 0.05005 | 85 | 4254.1 | 10,000,000 | Run-out |
| 13-8B-2 | -1 | RT | 0.75 | 0.2520 | 0.04985 | 85 | 4237.3 | 10,000,000 | Run-out |
| 13-8B-3 | -1 | RT | 0.75 | 0.2535 | 0.05047 | 85 | 4290.0 | 10,000,000 | Run-out |
| 13-8B-4 | -1 | RT | 0.75 | 0.2530 | 0.05027 | 85 | 4273.0 | 10,000,000 | Run-out |
| | | | | | | | | | |

COMMENTS: High cycle fatigue – Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 02-Dec-01

Total Number of Specimens: 4

Material Description: 13-8PH

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: N/A

Load Cell Range: 25 kips
Extensometer Range: N/A

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

Alignment Method: MTS EZALIGN
Test Rate: 30 Hz

TEST RESULTS

| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|---------------|---------------------------------|--------------|------------|------------|---------|
| 13-8B-13 | 0.1 | RT | 0.75 | 0.2525 | 0.05005 | 150 | 7507.5 | 10,000,000 | Run-out |
| 13-8B-14 | 0.1 | RT | 0.75 | 0.2525 | 0.05005 | 150 | 7507.5 | 10,000,000 | Run-out |
| 13-8B-15 | 0.1 | RT | 0.75 | 0.2525 | 0.05005 | 150 | 7507.5 | 10,000,000 | Run-out |
| 13-8B-16 | 0.1 | RT | 0.75 | 0.2525 | 0.05005 | 150 | 7507.5 | 10,000,000 | Run-out |

COMMENTS: High cycle fatigue – Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 03-Jan-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 13-Mar-02

Total Number of Specimens: 4

Material Description: 13-8PH chrome plated (EHC)

| TEST MACHINE: 20 KIP MTS (RM 206C) | | | | | Settings: | | Specimen: | | |
|---|--------------|--|--------------------|---------------|---|--------------|------------|--------|----------------------|
| Load Cell S/N: 815 Extensometer S/N: N/A | | Load Cell Range: 25 kips Extensometer Range: N/A | | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | |
| | | Alignment Method: Dial indicator Test Rate: 30 Hz | | | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 13-8B-5 | -1 | RT | 0.75 | 0.2590 | 0.05269 | 85 | 4478.7 | 37,705 | Broke in gage length |
| 13-8B-6 | -1 | RT | 0.75 | 0.2565 | 0.05168 | 85 | 4392.3 | 36,142 | Broke in gage length |
| 13-8B-7 | -1 | RT | 0.75 | 0.2580 | 0.05228 | 85 | 4443.9 | 36,958 | Broke in gage length |
| 13-8B-8 | -1 | RT | 0.75 | 0.2595 | 0.05289 | 85 | 4495.7 | 41,340 | Broke in gage length |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Robert E. Taylor (signature on file)

Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 14-Mar-02

Total Number of Specimens: 4

Material Description: 13-8PH chrome plated (EHC)

| TEST MACHINE: 20 KIP MTS (RM 206C) | | | | Settings: | | Specimen: | | | |
|---|--------------|--|--------------------|---|---------------------------------|--------------|------------|--------|----------------------|
| Load Cell S/N: 815 Extensometer S/N: N/A | | Load Cell Range: 10 kips Extensometer Range: N/A | | Geometry: 0.25 in. diameter Nominal Gage: 0.75 in. | | | | | |
| | | Alignment Method: Dial indicator Test Rate: 30 Hz | | | | | | | |
| TEST RESULTS | | | | | | | | | |
| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter(i n.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
| 13-8B-17 | 0.1 | RT | 0.75 | 0.2585 | 0.05248 | 150 | 7872.5 | 14,912 | Broke in gage length |
| 13-8B-18 | 0.1 | RT | 0.75 | 0.2575 | 0.05208 | 150 | 7812.0 | 18,228 | Broke in gage length |
| 13-8B-19 | 0.1 | RT | 0.75 | 0.2575 | 0.05208 | 150 | 7812.0 | 17,786 | Broke in gage length |
| 13-8B-20 | 0.1 | RT | 0.75 | 0.2575 | 0.05208 | 150 | 7812.0 | 15,650 | Broke in gage length |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Robert E. Taylor (signature on file)

Date: 19-Mar-02

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: 13-8PH chrome plated with fume suppressant (EHC/FS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: N/A

Load Cell Range: 25 kips
Extensometer Range: N/A

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

Alignment Method: Dial indicator
Test Rate: 30 Hz

TEST RESULTS

| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|--------------|------------|--------|---|
| 13-8B-9 | -1 | RT | 0.75 | 0.2560 | 0.05147 | 85 | 4375.0 | 55,892 | Failed in upper center inside gage length |
| 13-8B-10 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 85 | 4324.0 | 60,771 | Failed in center |
| 13-8B-11 | -1 | RT | 0.75 | 0.2545 | 0.05087 | 85 | 4324.0 | 61,173 | Failed in center |
| 13-8B-12 | -1 | RT | 0.75 | 0.2535 | 0.05047 | 85 | 4290.0 | 62,901 | Failed in center |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

FATIGUE DATA REPORT
Mechanical Test Laboratory, RM 106A

Laboratory Report: MT1089

Test Completion Date: 12-Feb-03

Total Number of Specimens: 4

Material Description: 13-8PH chrome plated with fume suppressant (EHC/FS)

| TEST MACHINE: INTERLAKEN | Settings: | Specimen: |
|--------------------------|-----------|-----------|
|--------------------------|-----------|-----------|

Load Cell S/N: 50071
Extensometer S/N: N/A
Load Cell Range: 25 kips
Extensometer Range: N/A
Alignment Method: Dial indicator
Test Rate: 30 Hz

Geometry: 0.25 in. diameter
Nominal Gage: 0.75 in.

TEST RESULTS

| Specimen ID | Stress Ratio | Temp (F) | Initial Gage (in.) | Diameter (in.) | Initial Area (in ²) | Stress (ksi) | Load (lbs) | Cycles | Remarks |
|-------------|--------------|----------|--------------------|----------------|---------------------------------|--------------|------------|--------|---|
| 13-8B-21 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 150 | 7660.5 | 20,697 | Failed in lower center inside gage length |
| 13-8B-22 | 0.1 | RT | 0.75 | 0.2550 | 0.05107 | 150 | 7660.5 | 20,944 | Failed in upper center inside gage length |
| 13-8B-23 | 0.1 | RT | 0.75 | 0.2535 | 0.05047 | 150 | 7570.5 | 25,142 | Failed in center |
| 13-8B-24 | 0.1 | RT | 0.75 | 0.2555 | 0.05127 | 150 | 7690.5 | 21,502 | Failed in center |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

COMMENTS: High cycle fatigue - Run-out defined as 10,000,000 cycles

Analyst: Henry C. Sanders (signature on file)

Date: 13-Feb-03

Appendix D - Axial Fatigue Test Matrix

Matrix 1_6

ESTCP WAFS Fatigue Testing
Plating Thickness: 3 mils on all samples

Strain Controlled Low-Cycle Fatigue
10,000 cycles @ 0.4 Hz

| Coupon # | Alloy | Coating | Approximate | | Cycles to Failure |
|----------|------------|------------|-------------|---------|-------------------|
| | | | R value | Strain | |
| 100A-1 | Aermet 100 | none | -1 | 0.00660 | |
| 100A-2 | Aermet 100 | none | -1 | 0.00660 | |
| 100A-3 | Aermet 100 | none | -1 | 0.00660 | |
| 100A-4 | Aermet 100 | none | -1 | 0.00660 | |
| 300A-1 | 300M | none | -1 | 0.00570 | |
| 300A-2 | 300M | none | -1 | 0.00570 | |
| 300A-3 | 300M | none | -1 | 0.00570 | |
| 300A-4 | 300M | none | -1 | 0.00570 | |
| 13-8A-1 | 13-8 | none | -1 | 0.00540 | |
| 13-8A-2 | 13-8 | none | -1 | 0.00540 | |
| 13-8A-3 | 13-8 | none | -1 | 0.00540 | |
| 13-8A-4 | 13-8 | none | -1 | 0.00540 | |
| 100A-5 | Aermet 100 | EHC | -1 | 0.00660 | |
| 100A-6 | Aermet 100 | EHC | -1 | 0.00660 | |
| 100A-7 | Aermet 100 | EHC | -1 | 0.00660 | |
| 100A-8 | Aermet 100 | EHC | -1 | 0.00660 | |
| 300A-5 | 300M | EHC | -1 | 0.00570 | |
| 300A-6 | 300M | EHC | -1 | 0.00570 | |
| 300A-7 | 300M | EHC | -1 | 0.00570 | |
| 300A-8 | 300M | EHC | -1 | 0.00570 | |
| 13-8A-5 | 13-8 | EHC | -1 | 0.00540 | |
| 13-8A-6 | 13-8 | EHC | -1 | 0.00540 | |
| 13-8A-7 | 13-8 | EHC | -1 | 0.00540 | |
| 13-8A-8 | 13-8 | EHC | -1 | 0.00540 | |
| 100A-9 | Aermet 100 | EHC w/WAFS | -1 | 0.00660 | |
| 100A-10 | Aermet 100 | EHC w/WAFS | -1 | 0.00660 | |
| 100A-11 | Aermet 100 | EHC w/WAFS | -1 | 0.00660 | |
| 100A-12 | Aermet 100 | EHC w/WAFS | -1 | 0.00660 | |
| 300A-9 | 300M | EHC w/WAFS | -1 | 0.00570 | |
| 300A-10 | 300M | EHC w/WAFS | -1 | 0.00570 | |
| 300A-11 | 300M | EHC w/WAFS | -1 | 0.00570 | |
| 300A-12 | 300M | EHC w/WAFS | -1 | 0.00570 | |
| 13-8A-9 | 13-8 | EHC w/WAFS | -1 | 0.00540 | |
| 13-8A-10 | 13-8 | EHC w/WAFS | -1 | 0.00540 | |
| 13-8A-11 | 13-8 | EHC w/WAFS | -1 | 0.00540 | |
| 13-8A-12 | 13-8 | EHC w/WAFS | -1 | 0.00540 | |
| 100A-13 | Aermet 100 | none | 0.1 | 0.01400 | |
| 100A-14 | Aermet 100 | none | 0.1 | 0.01400 | |
| 100A-15 | Aermet 100 | none | 0.1 | 0.01400 | |
| 100A-16 | Aermet 100 | none | 0.1 | 0.01400 | |
| 300A-13 | 300M | none | 0.1 | 0.01100 | |
| 300A-14 | 300M | none | 0.1 | 0.01100 | |
| 300A-15 | 300M | none | 0.1 | 0.01100 | |
| 300A-16 | 300M | none | 0.1 | 0.01100 | |
| 13-8A-13 | 13-8 | none | 0.1 | 0.00800 | |
| 13-8A-14 | 13-8 | none | 0.1 | 0.00800 | |
| 13-8A-15 | 13-8 | none | 0.1 | 0.00800 | |
| 13-8A-16 | 13-8 | none | 0.1 | 0.00800 | |
| 100A-17 | Aermet 100 | EHC | 0.1 | 0.01400 | |
| 100A-18 | Aermet 100 | EHC | 0.1 | 0.01400 | |
| 100A-19 | Aermet 100 | EHC | 0.1 | 0.01400 | |
| 100A-20 | Aermet 100 | EHC | 0.1 | 0.01400 | |
| 300A-17 | 300M | EHC | 0.1 | 0.01100 | |
| 300A-18 | 300M | EHC | 0.1 | 0.01100 | |
| 300A-19 | 300M | EHC | 0.1 | 0.01100 | |
| 300A-20 | 300M | EHC | 0.1 | 0.01100 | |
| 13-8A-17 | 13-8 | EHC | 0.1 | 0.00800 | |
| 13-8A-18 | 13-8 | EHC | 0.1 | 0.00800 | |
| 13-8A-19 | 13-8 | EHC | 0.1 | 0.00800 | |
| 13-8A-20 | 13-8 | EHC | 0.1 | 0.00800 | |
| 100A-21 | Aermet 100 | EHC w/WAFS | 0.1 | 0.01400 | |
| 100A-22 | Aermet 100 | EHC w/WAFS | 0.1 | 0.01400 | |
| 100A-23 | Aermet 100 | EHC w/WAFS | 0.1 | 0.01400 | |
| 100A-24 | Aermet 100 | EHC w/WAFS | 0.1 | 0.01400 | |
| 300A-21 | 300M | EHC w/WAFS | 0.1 | 0.01100 | |
| 300A-22 | 300M | EHC w/WAFS | 0.1 | 0.01100 | |
| 300A-23 | 300M | EHC w/WAFS | 0.1 | 0.01100 | |
| 300A-24 | 300M | EHC w/WAFS | 0.1 | 0.01100 | |
| 13-8A-21 | 13-8 | EHC w/WAFS | 0.1 | 0.00800 | |
| 13-8A-22 | 13-8 | EHC w/WAFS | 0.1 | 0.00800 | |
| 13-8A-23 | 13-8 | EHC w/WAFS | 0.1 | 0.00800 | |

Stress Controlled High-Cycle Fatigue
10,000,000 cycles @ 30 Hz

| Coupon # | Alloy | Coating | R value | Approximate | |
|----------|------------|------------|---------|--------------|-------------------|
| | | | | Stress (ksi) | Cycles to Failure |
| 100B-1 | Aermet 100 | none | -1 | 110 | |
| 100B-2 | Aermet 100 | none | -1 | 110 | |
| 100B-3 | Aermet 100 | none | -1 | 110 | |
| 100B-4 | Aermet 100 | none | -1 | 110 | |
| 300B-1 | 300M | none | -1 | 95 | |
| 300B-2 | 300M | none | -1 | 95 | |
| 300B-3 | 300M | none | -1 | 95 | |
| 300B-4 | 300M | none | -1 | 95 | |
| 13-8B-1 | 13-8 | none | -1 | 85 | |
| 13-8B-2 | 13-8 | none | -1 | 85 | |
| 13-8B-3 | 13-8 | none | -1 | 85 | |
| 13-8B-4 | 13-8 | none | -1 | 85 | |
| 100B-5 | Aermet 100 | EHC | -1 | 110 | |
| 100B-6 | Aermet 100 | EHC | -1 | 110 | |
| 100B-7 | Aermet 100 | EHC | -1 | 110 | |
| 100B-8 | Aermet 100 | EHC | -1 | 110 | |
| 300B-5 | 300M | EHC | -1 | 95 | |
| 300B-6 | 300M | EHC | -1 | 95 | |
| 300B-7 | 300M | EHC | -1 | 95 | |
| 300B-8 | 300M | EHC | -1 | 95 | |
| 13-8B-5 | 13-8 | EHC | -1 | 85 | |
| 13-8B-6 | 13-8 | EHC | -1 | 85 | |
| 13-8B-7 | 13-8 | EHC | -1 | 85 | |
| 13-8B-8 | 13-8 | EHC | -1 | 85 | |
| 100B-9 | Aermet 100 | EHC w/WAFS | -1 | 110 | |
| 100B-10 | Aermet 100 | EHC w/WAFS | -1 | 110 | |
| 100B-11 | Aermet 100 | EHC w/WAFS | -1 | 110 | |
| 100B-12 | Aermet 100 | EHC w/WAFS | -1 | 110 | |
| 300B-9 | 300M | EHC w/WAFS | -1 | 95 | |
| 300B-10 | 300M | EHC w/WAFS | -1 | 95 | |
| 300B-11 | 300M | EHC w/WAFS | -1 | 95 | |
| 300B-12 | 300M | EHC w/WAFS | -1 | 95 | |
| 13-8B-9 | 13-8 | EHC w/WAFS | -1 | 85 | |
| 13-8B-10 | 13-8 | EHC w/WAFS | -1 | 85 | |
| 13-8B-11 | 13-8 | EHC w/WAFS | -1 | 85 | |
| 13-8B-12 | 13-8 | EHC w/WAFS | -1 | 85 | |
| 100B-13 | Aermet 100 | none | 0.1 | 160 | |
| 100B-14 | Aermet 100 | none | 0.1 | 160 | |
| 100B-15 | Aermet 100 | none | 0.1 | 160 | |
| 100B-16 | Aermet 100 | none | 0.1 | 160 | |
| 300B-13 | 300M | none | 0.1 | 135 | |
| 300B-14 | 300M | none | 0.1 | 135 | |
| 300B-15 | 300M | none | 0.1 | 135 | |
| 300B-16 | 300M | none | 0.1 | 135 | |
| 13-8B-13 | 13-8 | none | 0.1 | 150 | |
| 13-8B-14 | 13-8 | none | 0.1 | 150 | |
| 13-8B-15 | 13-8 | none | 0.1 | 150 | |
| 13-8B-16 | 13-8 | none | 0.1 | 150 | |
| 100B-17 | Aermet 100 | EHC | 0.1 | 160 | |
| 100B-18 | Aermet 100 | EHC | 0.1 | 160 | |
| 100B-19 | Aermet 100 | EHC | 0.1 | 160 | |
| 100B-20 | Aermet 100 | EHC | 0.1 | 160 | |
| 300B-17 | 300M | EHC | 0.1 | 135 | |
| 300B-18 | 300M | EHC | 0.1 | 135 | |
| 300B-19 | 300M | EHC | 0.1 | 135 | |
| 300B-20 | 300M | EHC | 0.1 | 135 | |
| 13-8B-17 | 13-8 | EHC | 0.1 | 150 | |
| 13-8B-18 | 13-8 | EHC | 0.1 | 150 | |
| 13-8B-19 | 13-8 | EHC | 0.1 | 150 | |
| 13-8B-20 | 13-8 | EHC | 0.1 | 150 | |
| 100B-21 | Aermet 100 | EHC w/WAFS | 0.1 | 160 | |
| 100B-22 | Aermet 100 | EHC w/WAFS | 0.1 | 160 | |
| 100B-23 | Aermet 100 | EHC w/WAFS | 0.1 | 160 | |
| 100B-24 | Aermet 100 | EHC w/WAFS | 0.1 | 160 | |
| 300B-21 | 300M | EHC w/WAFS | 0.1 | 135 | |
| 300B-22 | 300M | EHC w/WAFS | 0.1 | 135 | |
| 300B-23 | 300M | EHC w/WAFS | 0.1 | 135 | |
| 300B-24 | 300M | EHC w/WAFS | 0.1 | 135 | |
| 13-8B-21 | 13-8 | EHC w/WAFS | 0.1 | 150 | |
| 13-8B-22 | 13-8 | EHC w/WAFS | 0.1 | 150 | |
| 13-8B-23 | 13-8 | EHC w/WAFS | 0.1 | 150 | |

Matrix 1_6

ESTCP WAFS Fatigue Testing
Plating Thickness: 3 mills on all samples

Strain Controlled Low-Cycle Fatigue
10,000 cycles @ 0.4 Hz

| Coupon # | Alloy | Coating | Approximate | | |
|----------|------------|------------|-------------|---------|-------------------|
| | | | R value | Strain | Cycles to Failure |
| 13-8A-24 | 13-8 | EHC w/WAFS | 0.1 | 0.00800 | |
| 100A-25 | Aermet 100 | none | -1 | 0.00660 | dummy |
| 100A-26 | Aermet 100 | none | -1 | 0.00660 | dummy |
| 100A-27 | Aermet 100 | none | -1 | 0.00660 | dummy |
| 300A-25 | 300M | none | -1 | 0.00570 | dummy |
| 300A-26 | 300M | none | -1 | 0.00570 | dummy |
| 300A-27 | 300M | none | -1 | 0.00570 | dummy |
| 13-8A-25 | 13-8 | none | -1 | 0.00540 | dummy |
| 13-8A-26 | 13-8 | none | -1 | 0.00540 | dummy |
| 13-8A-27 | 13-8 | none | -1 | 0.00540 | dummy |
| 100A-28 | Aermet 100 | EHC | -1 | 0.00660 | dummy |
| 100A-29 | Aermet 100 | EHC | -1 | 0.00660 | dummy |
| 100A-30 | Aermet 100 | EHC | -1 | 0.00660 | dummy |
| 300A-28 | 300M | EHC | -1 | 0.00570 | dummy |
| 300A-29 | 300M | EHC | -1 | 0.00570 | dummy |
| 300A-30 | 300M | EHC | -1 | 0.00570 | dummy |
| 13-8A-28 | 13-8 | EHC | -1 | 0.00540 | dummy |
| 13-8A-29 | 13-8 | EHC | -1 | 0.00540 | dummy |
| 13-8A-30 | 13-8 | EHC | -1 | 0.00540 | dummy |
| 100A-31 | Aermet 100 | none | 0.1 | 0.01400 | dummy |
| 100A-32 | Aermet 100 | none | 0.1 | 0.01400 | dummy |
| 100A-33 | Aermet 100 | none | 0.1 | 0.01400 | dummy |
| 300A-31 | 300M | none | 0.1 | 0.01100 | dummy |
| 300A-32 | 300M | none | 0.1 | 0.01100 | dummy |
| 300A-33 | 300M | none | 0.1 | 0.01100 | dummy |
| 13-8A-31 | 13-8 | none | 0.1 | 0.00800 | dummy |
| 13-8A-32 | 13-8 | none | 0.1 | 0.00800 | dummy |
| 13-8A-33 | 13-8 | none | 0.1 | 0.00800 | dummy |
| 100A-34 | Aermet 100 | EHC | 0.1 | 0.01400 | dummy |
| 100A-35 | Aermet 100 | EHC | 0.1 | 0.01400 | dummy |
| 100A-36 | Aermet 100 | EHC | 0.1 | 0.01400 | dummy |
| 300A-34 | 300M | EHC | 0.1 | 0.01100 | dummy |
| 300A-35 | 300M | EHC | 0.1 | 0.01100 | dummy |
| 300A-36 | 300M | EHC | 0.1 | 0.01100 | dummy |
| 13-8A-34 | 13-8 | EHC | 0.1 | 0.00800 | dummy |
| 13-8A-35 | 13-8 | EHC | 0.1 | 0.00800 | dummy |
| 13-8A-36 | 13-8 | EHC | 0.1 | 0.00800 | dummy |

Stress Controlled High-Cycle Fatigue
10,000,000 cycles @ 30 Hz

| Coupon # | Alloy | Coating | Approximate | | |
|----------|------------|------------|-------------|--------------|-------------------|
| | | | R value | Stress (ksi) | Cycles to Failure |
| 13-8B-24 | 13-8 | EHC w/WAFS | 0.1 | 150 | |
| 100B-25 | Aermet 100 | none | -1 | 110 | dummy |
| 100B-26 | Aermet 100 | none | -1 | 110 | dummy |
| 100B-27 | Aermet 100 | none | -1 | 110 | dummy |
| 300B-25 | 300M | none | -1 | 95 | dummy |
| 300B-26 | 300M | none | -1 | 95 | dummy |
| 300B-27 | 300M | none | -1 | 95 | dummy |
| 13-8B-25 | 13-8 | none | -1 | 85 | dummy |
| 13-8B-26 | 13-8 | none | -1 | 85 | dummy |
| 13-8B-27 | 13-8 | none | -1 | 85 | dummy |
| 100B-28 | Aermet 100 | EHC | -1 | 110 | dummy |
| 100B-29 | Aermet 100 | EHC | -1 | 110 | dummy |
| 100B-30 | Aermet 100 | EHC | -1 | 110 | dummy |
| 300B-28 | 300M | EHC | -1 | 95 | dummy |
| 300B-29 | 300M | EHC | -1 | 95 | dummy |
| 300B-30 | 300M | EHC | -1 | 95 | dummy |
| 13-8B-28 | 13-8 | EHC | -1 | 85 | dummy |
| 13-8B-29 | 13-8 | EHC | -1 | 85 | dummy |
| 13-8B-30 | 13-8 | EHC | -1 | 85 | dummy |
| 100B-31 | Aermet 100 | none | 0.1 | 160 | dummy |
| 100B-32 | Aermet 100 | none | 0.1 | 160 | dummy |
| 100B-33 | Aermet 100 | none | 0.1 | 160 | dummy |
| 300B-31 | 300M | none | 0.1 | 135 | dummy |
| 300B-32 | 300M | none | 0.1 | 135 | dummy |
| 300B-33 | 300M | none | 0.1 | 135 | dummy |
| 13-8B-31 | 13-8 | none | 0.1 | 150 | dummy |
| 13-8B-32 | 13-8 | none | 0.1 | 150 | dummy |
| 13-8B-33 | 13-8 | none | 0.1 | 150 | dummy |
| 100B-34 | Aermet 100 | EHC | 0.1 | 160 | dummy |
| 100B-35 | Aermet 100 | EHC | 0.1 | 160 | dummy |
| 100B-36 | Aermet 100 | EHC | 0.1 | 160 | dummy |
| 300B-34 | 300M | EHC | 0.1 | 135 | dummy |
| 300B-35 | 300M | EHC | 0.1 | 135 | dummy |
| 300B-36 | 300M | EHC | 0.1 | 135 | dummy |
| 13-8B-34 | 13-8 | EHC | 0.1 | 150 | dummy |
| 13-8B-35 | 13-8 | EHC | 0.1 | 150 | dummy |
| 13-8B-36 | 13-8 | EHC | 0.1 | 150 | dummy |

| | Unplated | EHC | EHC w/WAFS | Total Alloy |
|------------------|----------|-----|------------|-------------|
| Total Aermet A/B | 14 | 14 | 8 | 36 |
| Total 300M A/B | 14 | 14 | 8 | 36 |
| Total 13-8 A/B | 14 | 14 | 8 | 36 |
| Total A/B | 42 | 42 | 24 | 108 |

APPENDIX G

ALTERNATIVE INDUSTRIAL HYGIENE SAMPLING RESULTS

ALTERNATIVE INDUSTRIAL HYGIENE SAMPLING DATA - also see NOTES
(concentrations in micrograms/cubic meter)

| NADEP CHERRY POINT | | | | TINKER AFB | | | |
|------------------------------|-----------------------------------|--------------------------|--------------|-----------------|-----------------------------------|--------------------------|---------------|
| Test Date | Hexavalent Chromium Concentration | | | Test Date | Hexavalent Chromium Concentration | | |
| | Remote Breathing Zone | Near Tank Breathing Zone | In Tank | | Remote Breathing Zone | Near Tank Breathing Zone | In Tank |
| 7/11/00 | 0.041 | 1.81 | 1.450 | 9/12/00 am | 0.115 | 15.8 | 0.201(note 3) |
| 7/12/00 | 0.033 | 0.077 | 1.250 | 9/12/00 pm | (note 4) | 0.022 | 0.252 |
| 9/21/00 am | 0.031 | 0.024 | 0.023 | 10/11/00 am | 0.007 | 0.035 | 0.023 |
| 9/21/00 pm | (note 4) | 0.043 | 0.043 | 10/11/00 pm | (note 4) | 0.028 | 0.033 |
| 11/15/00 am | 0.056 | 0.112 | 2.266 | 11/8/00 am | 0.047 | 0.014 | 0.036 |
| 11/15/00 pm | (note 4) | (note 4) | 2.400 | 11/8/00 pm | (note 4) | (note 4) | 0.078 |
| 11/16/00 am | 0.042 | 0.035 | 0.070 | 12/6/00 | 0.028 | 0.042 | 0.100 |
| 11/16/00 pm | (note 4) | (note 4) | 0.120 | 7/31/01 | 0.023 | 0.038 | 0.053 |
| 12/13/00 am | 0.014 | 0.030 | 0.113 | 8/1/01 (note 5) | 0.050 | 0.018 | 16.42 |
| 12/13/00 pm | (note 4) | 0.030 | 0.075 | | | | |
| 3/27/01 | 0.014 | 0.186 | 0.073 | | | | |
| 4/17/01 | 0.028 | 0.014 | 0.041 | | | | |
| Averages⁶: | | | | | | | |
| without FS: | 0.043 | 0.667 | 1.68 | | 0.083 | 3.96 | 8.32 |
| with FS: | 0.026 | 0.060 | 0.067 | | 0.026 | 0.031 | 0.060 |

NOTES:

- 1 - Rows with shaded background represent baseline data (i.e., without fume suppressant [FS]).
- 2 - All values reported below various detection limits were averaged as the detection limit divided by the square root of 2 (i.e., 1.414).
For example: if non-detect was less than 0.020 mic/cu.m. then it was reported as 0.014 (i.e., 0.020/1.414) - see reference 5.
- 3 - For Tinker AFB, a value of 585 mic/cu.m. was considered an outlier from the 9/12/00 am sampling for "In Tank", and was not included in the calculations.
- 4 - Only one set of samples was taken during the day, spanning the entire day (i.e., am plus pm). The value shown for "am" represents the entire day.
- 5 - This baseline sample was taken on Tank 214. All other data were for Tank 222.
- 6 - To calculate averages, concentrations based on a full-day sampling were given twice the weight as concentrations based on half-day sampling.

For REFERENCE:

- 1 - Occupational Safety and Health Administration (OSHA) Permissible Exposure Limit (PEL) is 100 micrograms per cubic meter (mic/cu.m.) as chromic oxide (52 mic/cu.m. as chromium).
- 2 - **Proposed** OSHA PEL ranges between 0.5 and 5 mic/cu.m.
- 3 - American Conference on Governmental Industrial Hygienists (ACGIH) Time Weighted Average (TWA) for water-soluble hexavalent chromium compounds is 50 mic/cu.m. as chromium.
- 4 - National Institute for Occupational Safety and Health (NIOSH) Recommended Exposure Limit (REL) for hexavalent chromium compounds is 1 mic/cu.m. as chromium.
- 5 - Navy Environmental Health Center (NEHC), Industrial Hygiene Field Operations Manual, Chapter 4, Section 8a.(3), page 4-22.

APPENDIX H

HYDROGEN EMBRITTLEMENT DOCUMENTATION

Appendix H1: Results of 200-Hour Sustained Tensile Load Tests

Erin Beck
Naval Air Warfare Center
Aircraft Division
Mail Stop 5
Building 2188
Patuxent River, MD 20670

Report Number 341824
Report Date 16-MAR-01
Page 1 of 2
Client Number 580375
Client Order 01V0691390024

RECEIVED 18 ASTM F519-97 Type 1a Notched Round Bars
from Dirats Lot AG
IDENT AS Follows
MATERIAL AISI 4340, Plated
CONDITION *
TEST TO Client Requirements
PURPOSE Hydrogen Embrittlement Relief Test

FAX 301-342-7566

PROPERTIES AS SUPPLIED

SUSTAINED LOAD TEST ON PLATED V-NOTCHED SPECIMENS PER ASTM F519-97

Disp

LOT A

S/N 1 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 3 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 4 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 5 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 6 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 7 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 8 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 9 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

Naval Air Warfare Center
Aircraft Division
Patuxent River, MD 20670

Report Number
Report Date
Page

341824
16-MAR-01
2 of 2

LOT B

S/N 1 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 3 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 4 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 5 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 6 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 7 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 8 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 9 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

Required: A plating process shall be considered acceptable quality if all four specimens life is 200 hours or greater.



WE CERTIFY THIS IS A TRUE COPY OF OUR RECORDS

Signed for J. Dirats and Co. by Eric E. Dirats, Audit Manager

NOTE: The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under federal law.

41 AIRPORT ROAD P.O. BOX 39 WESTFIELD, MA 01086-0039 FAX 413-568-1453 413-568-1571

Erin Beck
Naval Air Warfare Center
Aircraft Division
Mail Stop 5
Building 2188
Patuxent River, MD 20670

Report Number 336726
Report Date 26-DEC-00
Page 1 of 2
Client Number 580375
Client Order 01V020650001

RECEIVED 10 ASTM F519-97 Type 1a Notched Round Bars
from Dirats Lot A1
IDENT AS Lot 3
MATERIAL AISI 4340, Plated
TEST TO Client Requirements
PURPOSE Hydrogen Embrittlement Relief Test
FAX 301-342-7566

01V020650001

the proper for

Cred
Cat

Dirats fax copy of invoice
to cardholder. Cardholder give
card# to Dirats over phone to P
the bill.
Resubmit the KMS if that person
not a cardholder anymore

PROPERTIES AS SUPPLIED

SUSTAINED LOAD TEST ON PLATED V-NOTCHED SPECIMENS PER ASTM F519-97

S/N 1 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

Disp
In Spec

S/N 2 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

S/N 3 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

S/N 4 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

S/N 5 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

S/N 6 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

S/N 7 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

S/N 8 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

Naval Air Warfare Center
Aircraft Division
Patuxent River, MD 20670

Report Number
Report Date
Page

336726
26-DEC-00
2 of 2

S/N 9 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

S/N 10 was stressed for 200 hours at 75% of the notched UTS 293.5 ksi.
Result: No rupture

In Spec

Required: A plating process shall be considered acceptable quality if all four specimens life is 200 hours or greater.



WE CERTIFY THIS IS A TRUE COPY OF OUR RECORDS

Signed for J. Dirats and Co. by Eric E. Dirats, Audit Manager

NOTE: The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under federal law.

A handwritten signature in black ink, appearing to be 'Eric E. Dirats', is written over the certification text.

41 AIRPORT ROAD P.O. BOX 39 WESTFIELD MA 01086-0039 FAX 413-568-1453 413-568-1571

Craig Matzdorf
Naval Air Warfare Center
Aircraft Division
Mail Stop 5
Building 2188
Patuxent River, MD 20670

Report Number 335047
Report Date 29-NOV-00
Page 1 of 2
Client Number 580375
Client Order 01V02650001

↑ ↑
0 6

RECEIVED 20 ASTM F519-97 Type 1a Notched Round Bars
from Dirats Lot AG
IDENT AS Follows
MATERIAL *
CONDITION *
TEST TO Client Requirements
FAX 301-342-7566

PROPERTIES AS SUPPLIED

SUSTAINED LOAD TEST ON PLATED V-NOTCHED SPECIMENS PER ASTM F519-97

Disp

S/N 1-1 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-2 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-3 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-4 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-5 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-6 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-7 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-8 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

Naval Air Warfare Center
Aircraft Division
Patuxent River, MD 20670

Report Number
Report Date
Page

335047
29-NOV-00
2 of 2

S/N 1-9 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 1-10
Sample was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-1 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-2 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-3 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-4 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-5 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-6 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-7 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-8 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-9 was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

S/N 2-10
Sample was stressed for 200 hours at 75% of the notched UTS 293.2 ksi.
Result: No rupture

In Spec

Required: A plating process shall be considered acceptable quality if all four specimens life is 200 hours or greater.



WE CERTIFY THIS IS A TRUE COPY OF OUR RECORDS

Signed for J. Dirats and Co. by Eric E. Dirats, Audit Manager

NOTE: The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under federal law.

Appendix H2: Sample Results of 24-Hour Rising Step Load Tests

Summary Table: Results of 24-Hour Rising Step Load Testing

Comparison of fracture % of chrome plated 4340 steel with and without Fumitrol

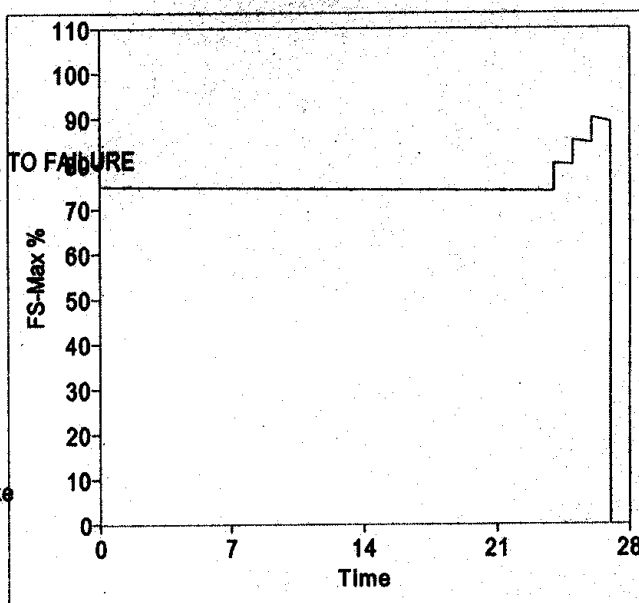
| Fracture % | | | | |
|--------------------------------------|-------------------------------------|-------------------------------------|--------------------------------|-------------------------------|
| Cherry Point w/o Fumitrol | Cherry Point w/ Fumitrol | North Island w/ Fumitrol | Tinker w/o Fumitrol | Tinker w/ Fumitrol |
| 92.6 | 92.8 | 91.0 | 93.7 | 93.8 |
| 87.8 | 91.4 | 93.6 | 94.3 | 93.3 |
| 91.2 | 89.0 | 91.4 | 91.5 | 93.8 |
| 90.0 | 90.2 | 94.2 | 93 | 94.7 |
| 92.3 | 92.7 | 91.1 | 92.3 | 93.3 |
| 90.2 | 89.5 | 92.7 | 93.7 | 90.2 |
| 93.1 | 90.2 | 93.2 | 93 | 93.3 |
| 92.2 | 94.1 | 93.2 | 93.5 | 92.8 |
| 74.0 | 93.2 | 93.1 | 90.6 | 93.8 |
| 90.0 | | 90.1 | | |
| 90.7 | | | | |
| | | | | |
| Average | 89.5 | 91.5 | 92.4 | 92.8 |
| | | | | 93.2 |

Example 24-Hour Rising Step Load Data for Each Set of Test Parameters
(Location, w/o WAFS, w/WAFS, no chrome control)

CP no WAFS Control

c:\rs\l\Craig Matzdorf\cp no wafs 24 hr bake 01.lst

Start Time: 09/14/00 11:01
 Lot ID: AG
 Sample #: 1465
 Sample Type: Notched Round Bar
 Method: 75% @ 24HR, STEP 5%/HR TO FAILURE
 Test Type: Tension
 Tensile Strength: 390.9 ksi
 Fracture Strength: 9403.0
 Fracture Load: 8706.1
 Fracture %: 92.6
 End Time: 09/15/00 14:01
 System: Ten.01
 Calibration Date: 09/14/00 10:59
 Process ID: CP wo Fumitrol w 24 hr bake
 Batch: Dirats/CP
 Potential: No Potential Applied
 Solution: Air



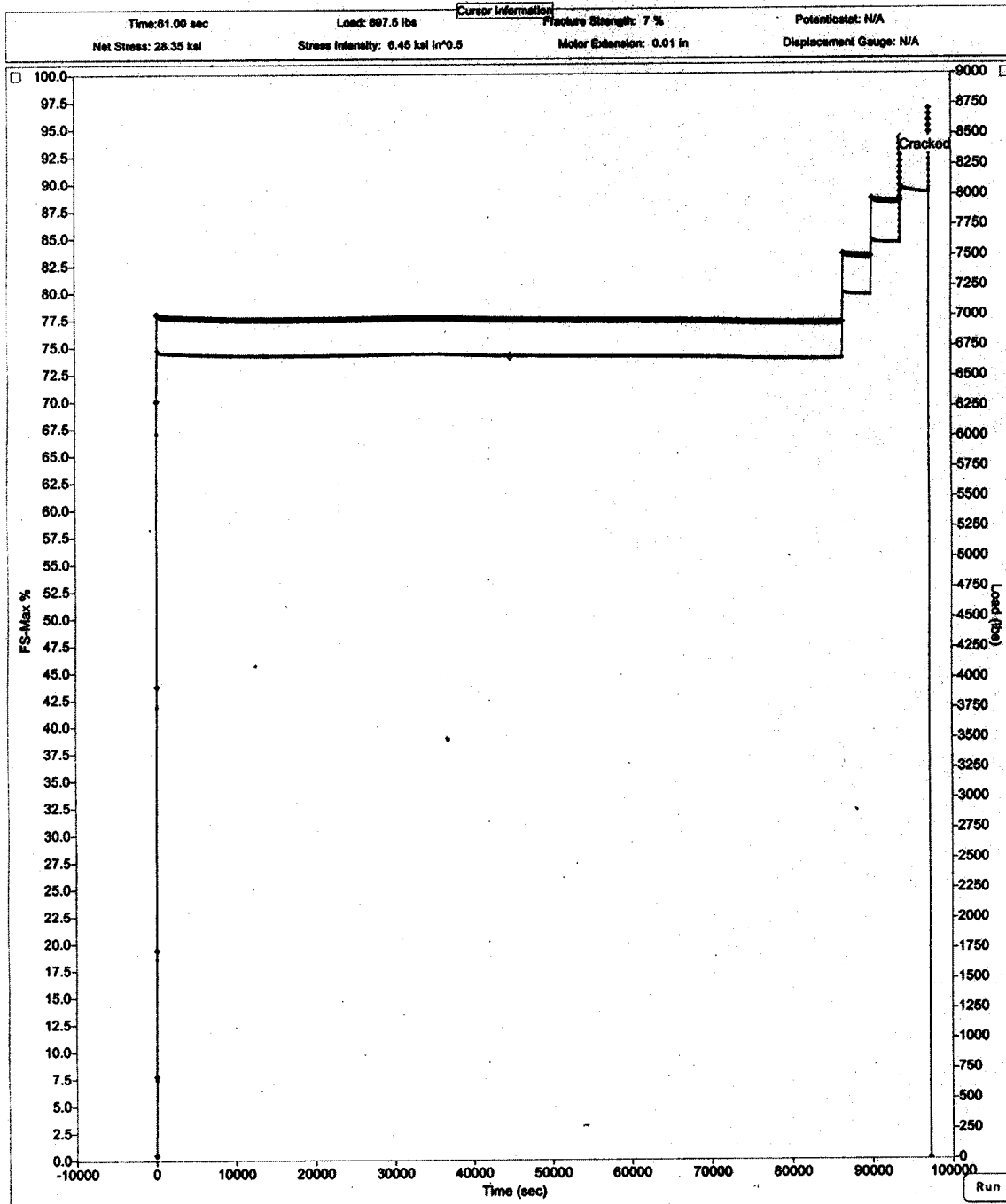
Comments:

| Step | Duration | Step % | Step Load | End Load | % Load Drop | Cumulative Time |
|------|----------|--------|-----------|----------|-------------|-----------------|
| 1 | 24.0 | 75% | 7052.3 | 6943.3 | 1% | 24.0 |
| 2 | 1.0 | 80% | 7522.9 | 7491.5 | 0% | 25.0 |
| 3 | 1.0 | 85% | 7992.9 | 7943.0 | 1% | 26.0 |
| 4 | 1.0 | 90% | 8465.1 | 8375.0 | 1% | 27.0 |
| 5 | 1.0 | 0% | 0.0 | 1.5 | 0% | 27.0 |

Sample Cracked at 93% of Fracture Strength on Step 5

Test Executed By: _____

Craig Matzdorf



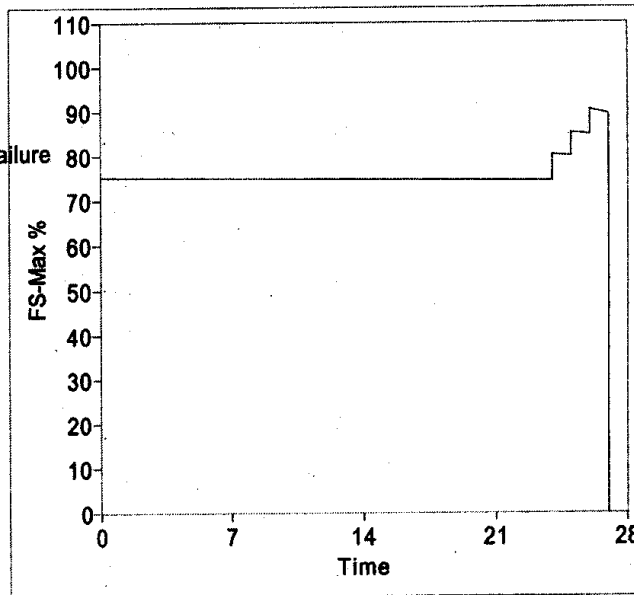
Comments:

| Test Information | | | Test Information | |
|------------------|---|----------------------------------|-----------------------------|--|
| Lot ID: AG | Fracture Strength: 9403.0 lbs | Environment: No Potential in Air | Started: 06/14/00 11:01 | |
| Sample: 1485 | Method: RSFS 75% @ 24HR, STEP 5%/HR TO FAILURE in Tension | System: Ten.01 | Status: Completed & Cracked | |

CP w WAFS

c:\rsi\l\Craig Matzdorf\cp w wafs01.tst

Start Time: 12/06/00 17:27
 Lot ID: AI
 Sample #: 2132
 Sample Type: Notched Round Bar
 Method: 75%@24hr, step 5%/hr to failure
 Test Type: Tension
 Tensile Strength: 391.3 ksi
 Fracture Strength: 9412.0
 Fracture Load: 8737.4
 Fracture %: 92.8
 End Time: 12/07/00 20:28
 System: Tens 01
 Calibration Date: 12/03/00 09:28
 Process ID: CP w Fumitrol w 24hr bake
 Batch: Dirats/CP
 Potential: No Potential Applied
 Solution: Air
 Comments:

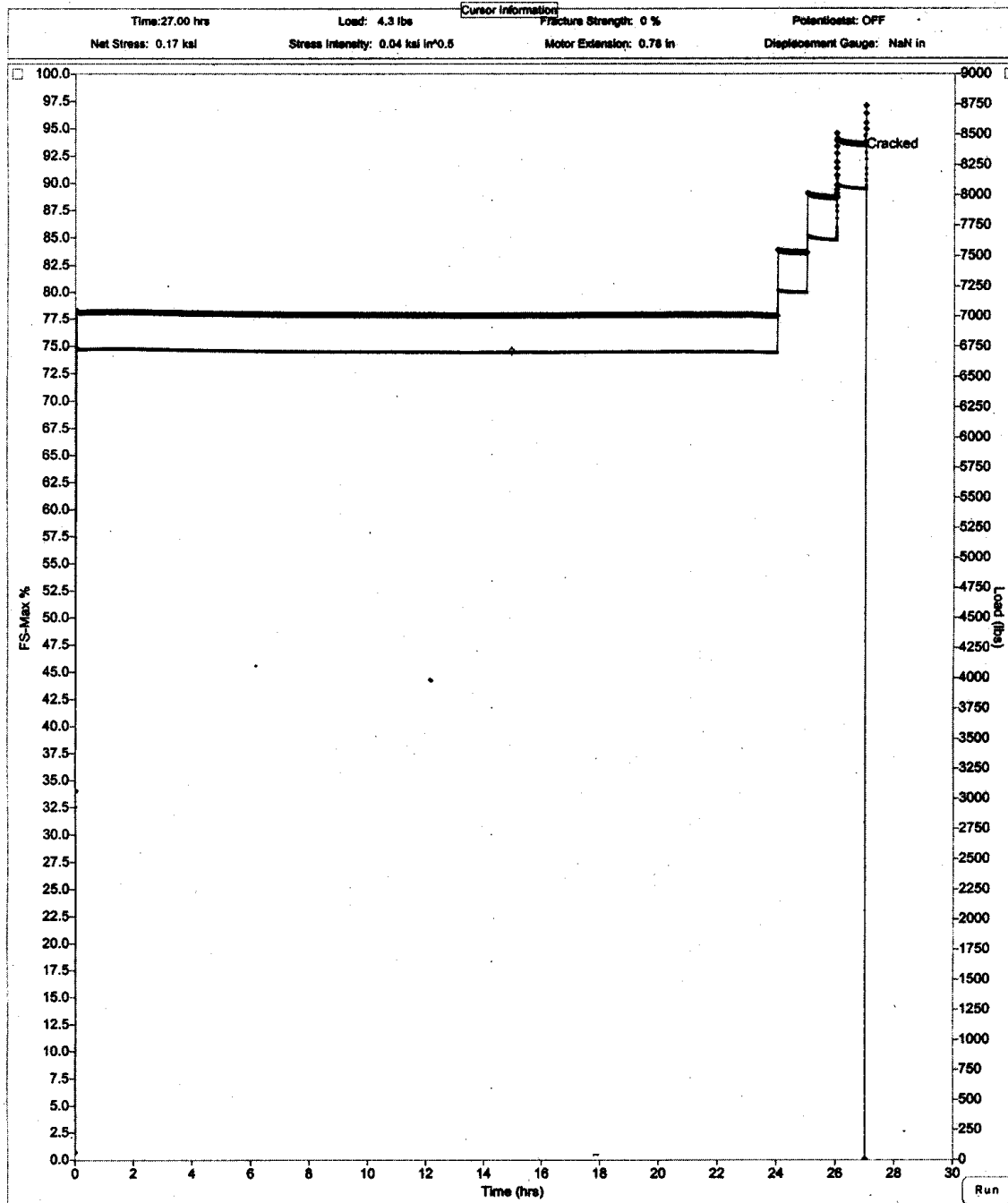


| Step | Duration | Step % | Step Load | End Load | % Load Drop | Cumulative Time |
|------|----------|--------|-----------|----------|-------------|-----------------|
| 1 | 24.0 | 75% | 7077.9 | 7002.9 | 1% | 24.0 |
| 2 | 1.0 | 80% | 7553.9 | 7527.2 | 0% | 25.0 |
| 3 | 1.0 | 85% | 8020.2 | 7977.3 | 0% | 26.0 |
| 4 | 1.0 | 90% | 8510.0 | 8417.6 | 1% | 27.0 |
| 5 | 1.0 | 0% | 0.0 | 4.3 | 0% | 27.0 |

Sample Cracked at 93% of Fracture Strength on Step 5

Test Executed By: _____

Craig Matzdorf



Comments:

| Test Information | | |
|------------------|--|----------------------------------|
| Lot ID: AI | Fracture Strength: 9412.0 lbs | Environment: No Potential in Air |
| Sample: 2132 | Method: RSFS 75% @ 24 hr, step 5%/hr to failure in Tension | System: Tens 01 |
| | | Started: 12/06/00 17:27 |
| | | Status: Completed & Cracked |

NI Furnitrol 140

c:\RSL\ACraig Matzdorf\North Island 01.tst

Start Time: 07/10/00 07:43

Lot ID: AG

Sample #: 1534

Sample Type: Notched Round Bar

Method: 75% @ 24HR, STEP 5%/HR TO FAILURE

Test Type: Tension

Tensile Strength: 390.9 ksi

Fracture Strength: 9403.0

Fracture Load: 8552.2

Fracture %: 91.0

End Time: 07/11/00 10:43

System: Ten.01

Calibration Date: 07/10/00 07:39

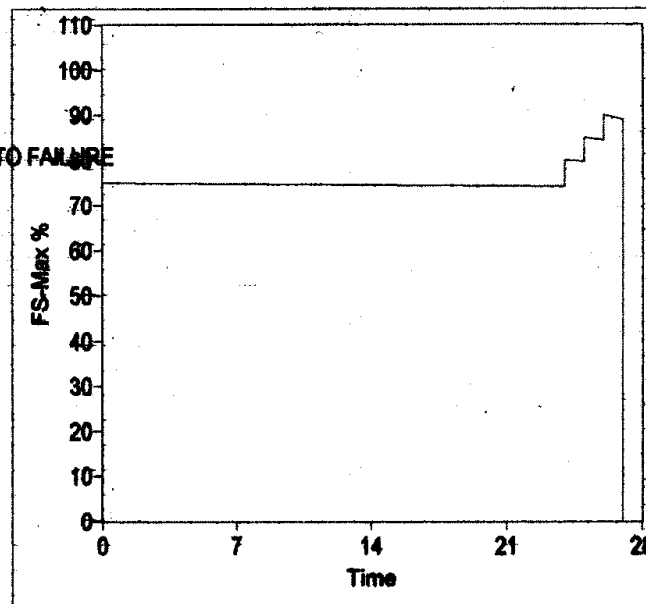
Process ID: Furnitrol 01

Batch: Dirats/NI

Potential: No Potential Applied

Solution: Air

Comments:

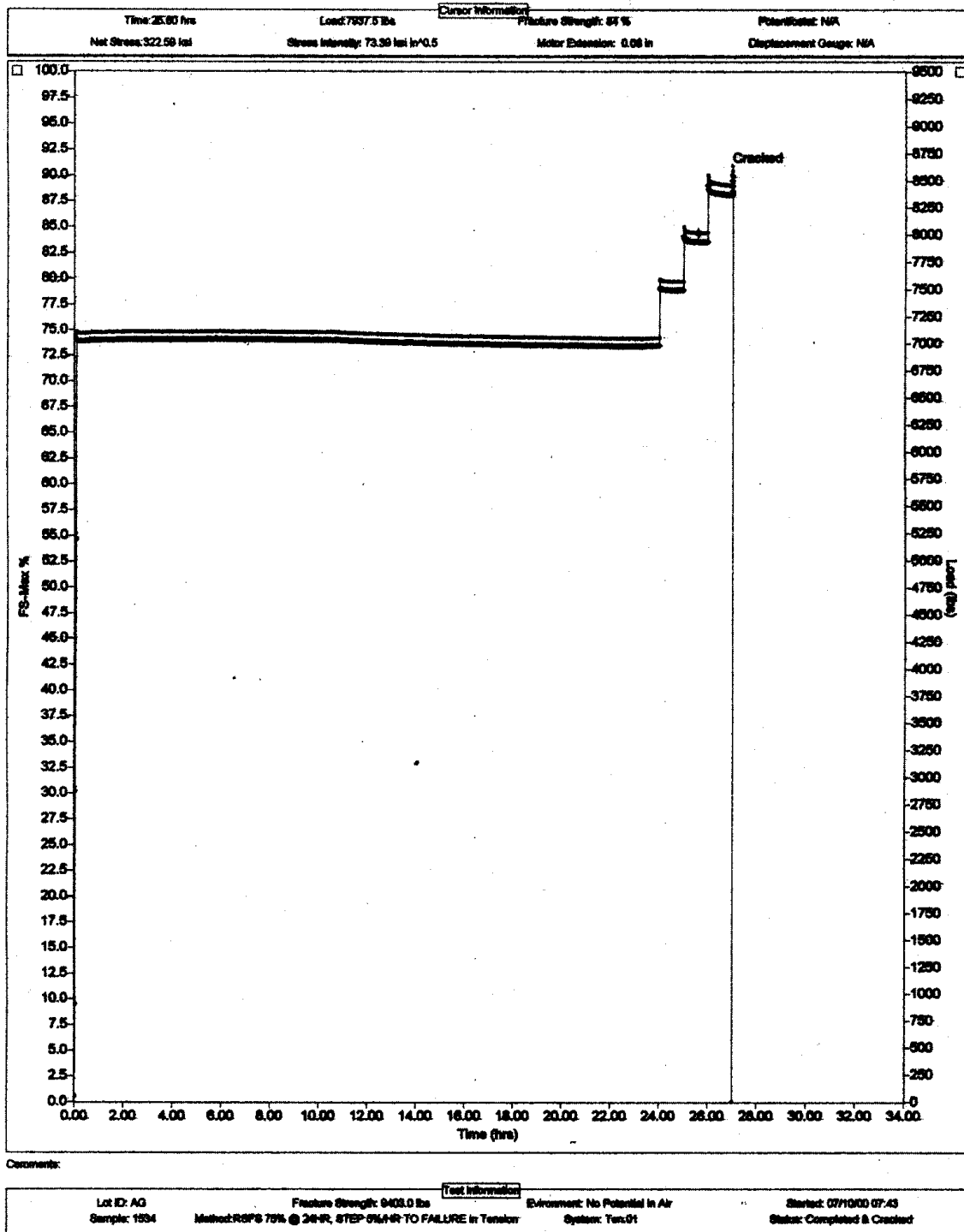


| Step | Duration | Step % | Step Load | End Load | % Load Drop | Cumulative Time |
|------|----------|--------|-----------|----------|-------------|-----------------|
| 1 | 24.0 | 75% | 7054.5 | 6979.5 | 1% | 24.0 |
| 2 | 1.0 | 80% | 7522.9 | 7497.3 | 0% | 25.0 |
| 3 | 1.0 | 85% | 7992.8 | 7937.3 | 1% | 26.0 |
| 4 | 1.0 | 90% | 8463.6 | 8370.0 | 1% | 27.0 |
| 5 | 1.0 | 0% | 0.0 | -0.6 | 0% | 27.0 |

Sample Cracked at 91% of Fracture Strength on Step 5

Test Executed By: _____

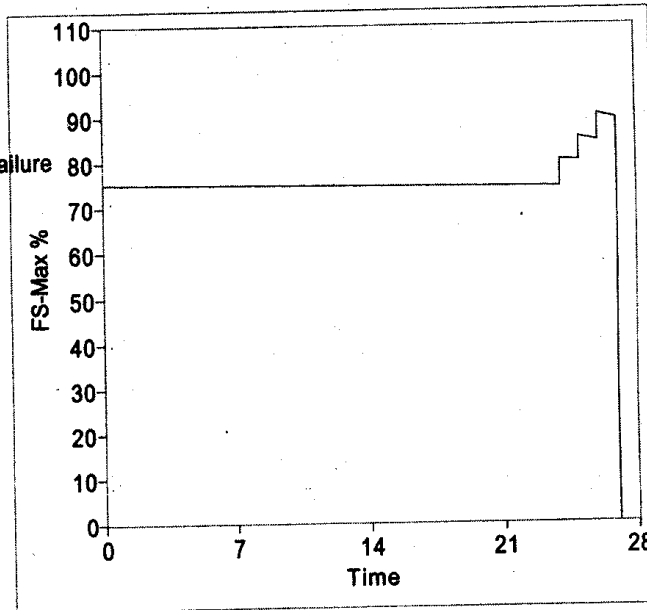
Dayle A. Conrad



ALC Lot "A"

c:\rsisi\Craig Matzdorf\ALC lot A 01.tst

Start Time: 01/22/01 08:39
 Lot ID: AG
 Sample #: 1141
 Sample Type: Notched Round Bar
 Method: 75%@24hr, step 5%/hr to failure
 Test Type: Tension
 Tensile Strength: 390.9 ksi
 Fracture Strength: 9403.0
 Fracture Load: 8818.9
 Fracture %: 93.8
 End Time: 01/23/01 11:40
 System: Tens 01
 Calibration Date: 12/03/00 09:28
 Process ID: ALC Lot "A"
 Batch: Dirats/ALC
 Potential: No Potential Applied
 Solution: Air
 Comments: Red rust on sample noted

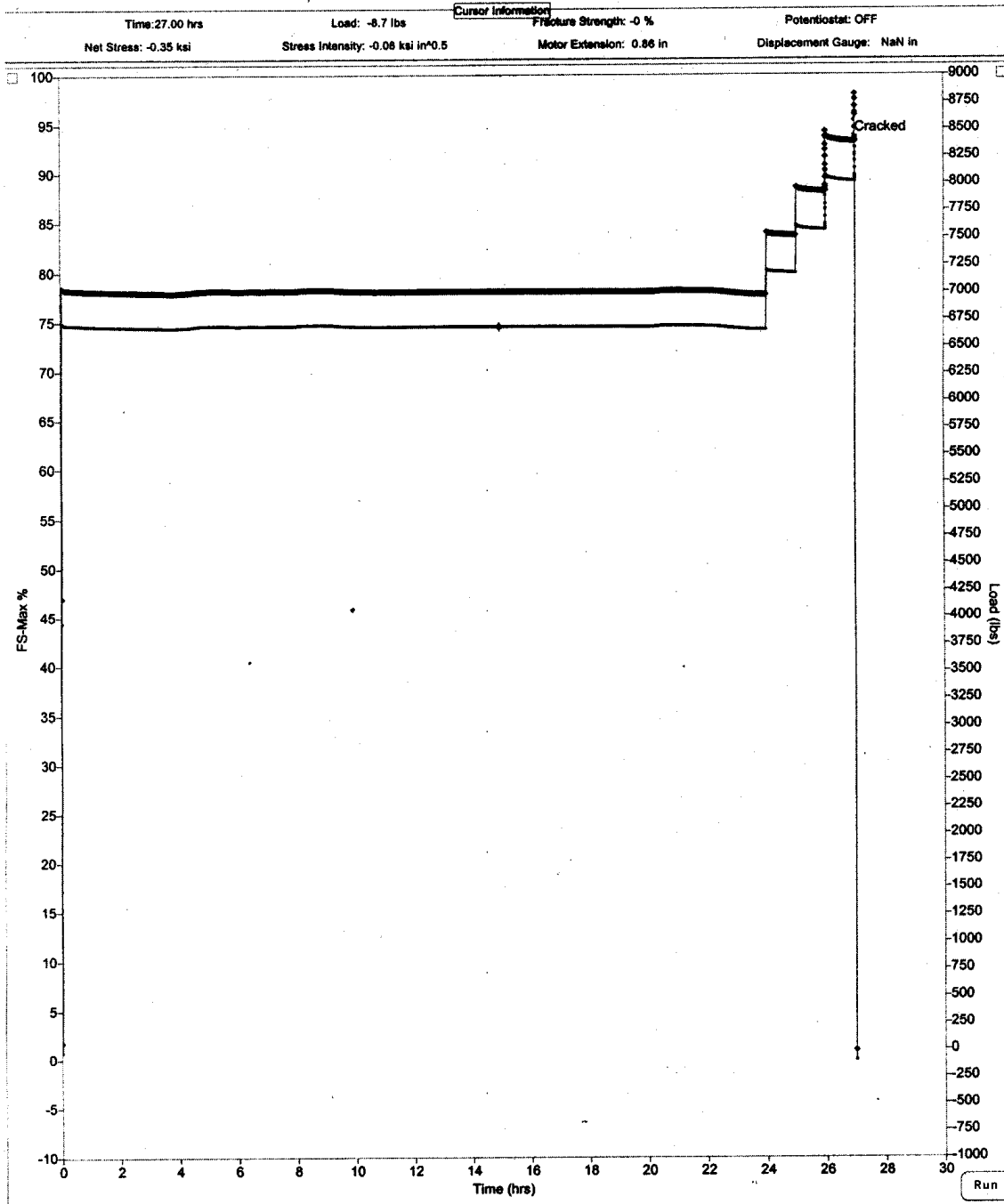


| Step | Duration | Step % | Step Load | End Load | % Load Drop | Cumulative Time |
|------|----------|--------|-----------|----------|-------------|-----------------|
| 1 | 24.0 | 75% | 7072.8 | 6973.8 | 1% | 24.0 |
| 2 | 1.0 | 80% | 7536.0 | 7513.1 | 0% | 25.0 |
| 3 | 1.0 | 85% | 7997.9 | 7917.4 | 1% | 26.0 |
| 4 | 1.0 | 90% | 8476.1 | 8380.0 | 1% | 27.0 |
| 5 | 1.0 | 0% | 0.0 | -8.7 | 0% | 27.0 |

Sample Cracked at 94% of Fracture Strength on Step 5

Test Executed By: _____

ICL



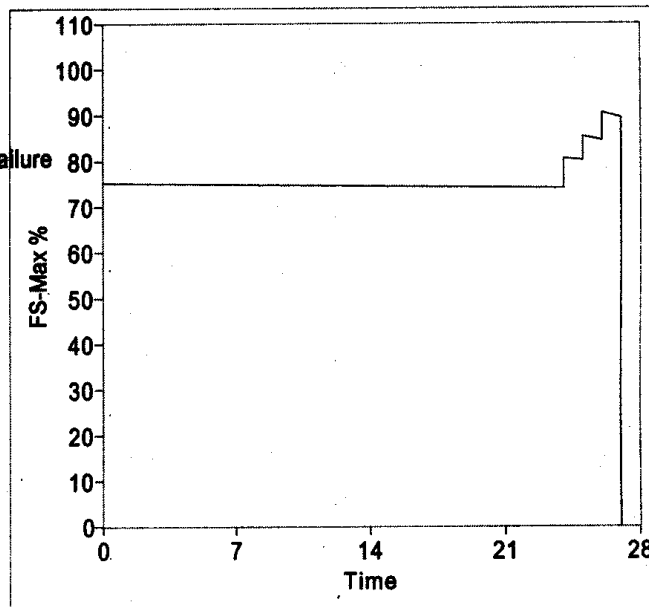
Comments: Red rust on sample noted

| Test Information | | |
|------------------|---|----------------------------------|
| Lot ID: AG | Fracture Strength: 9403.0 lbs | Environment: No Potential in Air |
| Sample: 1141 | Method: RSFS 75% @ 24hr, step 5%/hr to failure in Tension | System: Tens 01 |
| | | Started: 01/22/01 08:39 |
| | | Status: Completed & Cracked |

ALC Lot "B"

c:\rslsi\Craig Matzdorf\ALC lot B 01.tst

Start Time: 02/08/01 08:27
 Lot ID: AG
 Sample #: 1314
 Sample Type: Notched Round Bar
 Method: 75%@24hr, step 5%/hr to failure
 Test Type: Tension
 Tensile Strength: 390.9 ksi
 Fracture Strength: 9403.0
 Fracture Load: 8517.6
 Fracture %: 90.6
 End Time: 02/09/01 11:27
 System: Tens 01
 Calibration Date: 12/03/00 09:28
 Process ID: ALC Lot "B"
 Batch: Dirats/ALC
 Potential: No Potential Applied
 Solution: Air

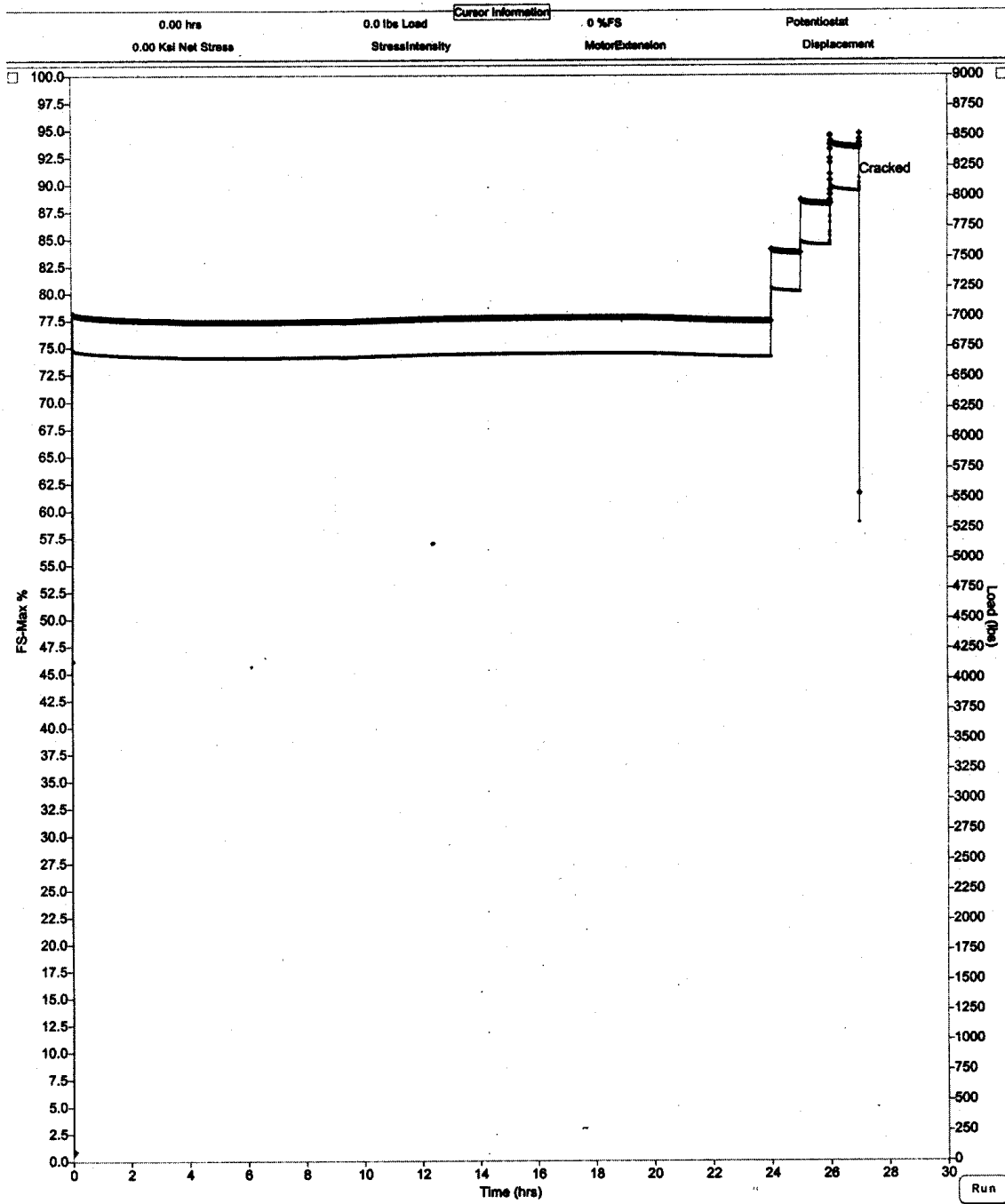


Comments:

| Step | Duration | Step % | Step Load | End Load | % Load Drop | Cumulative Time |
|------|----------|--------|-----------|----------|-------------|-----------------|
| 1 | 24.0 | 75% | 7074.6 | 6964.3 | 1% | 24.0 |
| 2 | 1.0 | 81% | 7570.8 | 7534.7 | 0% | 25.0 |
| 3 | 1.0 | 85% | 8019.5 | 7938.7 | 1% | 26.0 |
| 4 | 1.0 | 90% | 8504.2 | 8403.4 | 1% | 27.0 |
| 5 | 1.0 | 0% | 0.0 | 5538.4 | -59% | 27.0 |

Sample Cracked at 91% of Fracture Strength on Step 5

Test Executed By: _____
 ICL



Comments:

Lot ID: AG
 Sample: 1314

Test Information
 Fracture Strength: 9403.0 lbs
 Method: RSFS 75% @ 24hr, step 5%/hr to failure in Tension

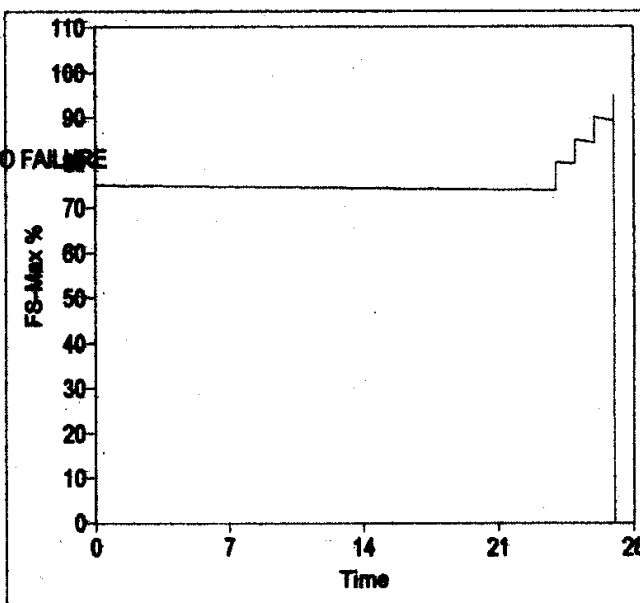
Environment: No Potential in Air
 System: Tens 01

Started: 02/08/01 08:27
 Status: Completed & Cracked

UNPLATED CONTROL 01

c:\RSL\SCraig Matzdorf\control01.tst

Start Time: 06/26/00 14:44
Lot ID: AG
Sample #: 1144
Sample Type: Notched Round Bar
Method: 75% @ 24HR, STEP 5%/HR TO FAILURE
Test Type: Tension
Tensile Strength: 390.9 ksi
Fracture Strength: 9403.0
Fracture Load: 8938.0
Fracture %: 95.1
End Time: 06/27/00 17:46
System: Ten.01
Calibration Date: 06/26/00 14:38
Process ID: UNPLATED CONTROL
Batch: DIRATS
Potential: No Potential Applied
Solution: Air
Comments:



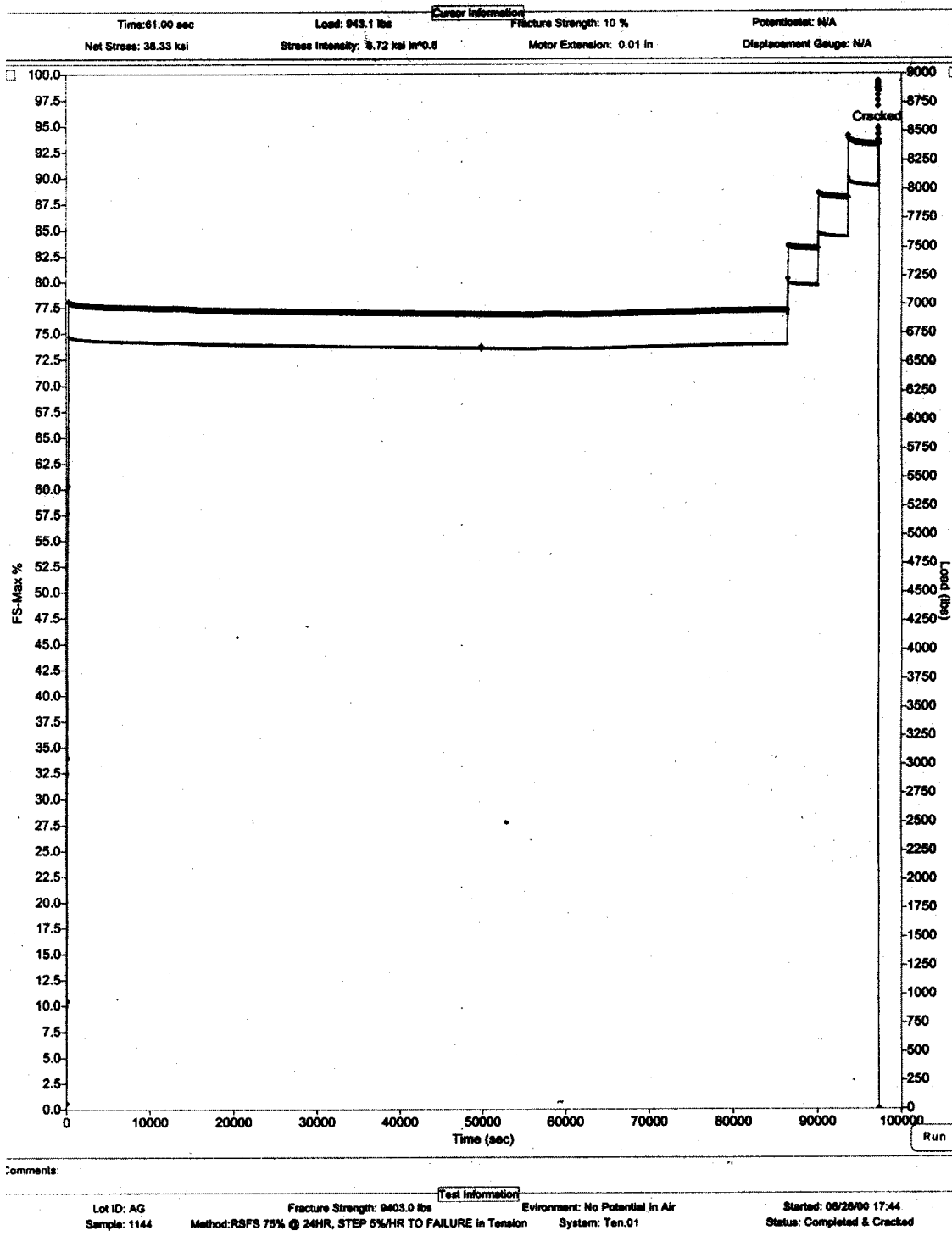
| Step | Duration | Step % | Step Load | End Load | % Load Drop | Cumulative Time |
|------|----------|--------|-----------|----------|-------------|-----------------|
| 1 | 24.0 | 75% | 7053.0 | 6948.0 | 1% | 24.0 |
| 2 | 1.0 | 80% | 7523.0 | 7491.3 | 0% | 25.0 |
| 3 | 1.0 | 85% | 7995.9 | 7926.8 | 1% | 26.0 |
| 4 | 1.0 | 90% | 8466.3 | 8387.5 | 1% | 27.0 |
| 5 | 1.0 | 95% | 8938.0 | 1.8 | 95% | 27.0 |

Sample Cracked at 95% of Fracture Strength on Step 5

Test Executed By: _____

Dayle A. Conrad

NAWCADPAX



APPENDIX I

Toxicology Reviews

From
Navy Environmental Health Center
and
Naval Toxicology Detachment

EDITOR: I have a letter that goes in here but I'm not sure of the best way to insert it.
What scanning extension should I use? I have a TIF file but it's not very pretty

PFOS as a Component of Fumetrol 140

Andrew J. Bobb, Ph.D., LT MSC USNR, Naval Health Research Center Toxicology Detachment, Dayton, OH

Perfluorooctanesulfonate (PFOS) and Perfluorooctanoic acid (PFOA) are structurally and chemically related synthetic perfluorinated surfactants used in a number of industrial applications, including plasticizers, lubricants, wetting agents, etc. They also appear to be the metabolic product of breakdown of other xenobiotic compounds (Olsen et al, 1999). Recent reports have suggested that these PFOS is nearly ubiquitous in the environment (Giesy and Kannan, 2001; Kannan et al 2001a; Kannan et al 2001b), and that it may bioaccumulate at higher levels in the food chain (Giesy and Kannan, 2001). Commercially available human serum (presumably without occupational exposure to PFOS) contains an average PFOS concentration of 24 ppb (Hansen et al, 2001)

RODENT DATA

Toxicity data from rodents suggests a high potential for liver toxicity for both compounds, and some evidence for developmental toxicity. Inhalation of the ammonium salt of PFOA at 8 or 84 mg/m³ results in liver-weight increases and microscopic liver necrosis in rats (Kennedy et al, 1986). No published data on inhalation PFOS exposure is available. Rats' gavaged with up to 50 mg/kg/day ammonium PFOA had significant increases in estrogen, and decreases in testosterone (Cook et al, 1992). Rats which were fed PFOA or PFOS exhibited reduced cholesterol synthesis and reduced serum triacylglycerides (Haughom and Spydevold, 1992). *In utero* exposure to PFOS at levels up to 1.0 mg/kg/day had no effect on rabbit pups up to the time of birth (Case et al, 2001a); but rat pups born to dams fed 1.6 mg/kg/day exhibited high infant mortality (Case et al 2001b).

HUMAN DATA

Humans have been regularly exposed to PFOA and PFOS in industrial synthesis plants. An epidemiological study of 2788 male and 749 female workers employed in a PFOA synthesis plant between 1947 and 1983 (Gilliland and Mandel, 1993) exhibited no significant deviations from unexposed individuals, except for a possible increase in prostate cancer deaths (4 deaths in exposed workers, 2 in unexposed). Another study of 115 occupationally exposed workers found no changes in hepatic enzymes, lipoproteins and cholesterol (Gilliland and Mandel, 1996). Another study of a total of 191 occupationally-exposed workers (performed in two different years) found no significant effect of PFOA on human hormone levels (Olsen et al, 1998); a similar study with PFOS using 317 male workers found no effects on serum hepatic enzymes, cholesterol, or lipoproteins (Olsen et al 1999). The half-life of PFOA in human systems is estimated to be 18 to 24 months (Ubel et al, 1980) and the half-life of PFOS may be even longer (Olsen et al, 1999).

APPLICATION AND CONCLUSIONS

There exists significant contradiction between the rodent and human data for PFOS/PFOA exposure. A potent liver toxicant in rodents should produce some level of toxicity in humans, particularly over the long exposure times; therefore it may be that the toxicity seen in rodents is the result of a mechanism which is not active in humans. This is not unprecedented; saccharin causes bladder tumors in rats (Reuber 1978) yet epidemiological data demonstrate that it is clearly noncarcinogenic in humans (Elcock and Morgan, 1993). Specific mechanisms exist in some animals, particularly in response to high-dose exposure, that render extrapolation between species impossible, for a particular effect (Cohen, 1995; Whysner and Williams, 1996).

The intended application for PFOS is as a mist suppressant (a component of Fumetrol 140 from ATOTECH USA) in chrome plating tanks. The primary hazard in such applications is hexavalent chromium a known carcinogen. Analysis of plating tank contents (Centre Analytical Laboratories, Inc., State College, PA) indicates a concentration of <37 mg/L. PFOS has a very low volatility (so much so that it has not been possible to obtain vapor inhalation toxicology data), therefore it is likely that the only airborne exposure will come from process-generated aerosols.

Given a lack of human exposure data (apart from cumulative serum levels) it is impossible to compare the animal and human data, or to derive a safe exposure level solely from the industrial exposure data. Both the liver toxicity and the potential reproductive toxicity (changes in hormone levels) exhibited in animal exposure data are specifically contradicted by human epidemiological data. There is, however, no evidence to suggest that the animal developmental toxicity data is inapplicable to humans. It seems therefore most conservative to base toxicity profiles on this data. The NOAEL is 1.0 mg/kg/day in rabbits (Case et al, 2001a). Adding an interspecific uncertainty factor of 10 and an intraspecific uncertainty factor of 5 (the epidemiological data suggest similar response to this compound between males and females- Gilliland and Mandel, 1993); we would derive a maximum daily dose of 0.02 mg/kg/day. For a 70 kg individual, therefore, the recommended limit would equate to drinking ~35 mL of tank contents, an unlikely exposure level. Furthermore, personnel likely to be exposed to PFOS from tanks or process-generated aerosols will be co-exposed to hexavalent chromium at much higher concentrations, and with much more serious health consequences. Measures in place to monitor or control chromium exposure will be more than adequate to protect the health of workers from PFOS, and that PFOS in chrome plating tanks will not significantly increase the risk of health consequences, barring any unforeseen complications of co-exposure.

- Case MT, York RG, Christian MS. 2001a. Rat and rabbit oral developmental toxicology studies with two perfluorinated compounds. *Int J Toxicol* 20:101-109
- Case MT, York RG, Buitenhoff JL. 2001b. Oral (gavage) cross-fostering study of potassium perfluorooctanesulfonate (PFOS) in rats. *Toxicologist* 60:221-222
- Cohen SM. 1995. Human relevance of animal carcinogenicity studies. *Regul Toxicol Pharmacol* 21: 75-80
- Cook JC, Murray SM, Frame SR, Hurtt ME. 1992. Induction of Leydig cell adenomas by ammonium perfluorooctanoate: a possible endocrine-related mechanism.
- Elcock M, Morgan RW. 1993. Update on artificial sweeteners and bladder cancer. *Regul Toxicol Pharmacol* 17: 35-43
- Giesy JP, Kannan K. 2001. Global distribution of perfluorooctane sulfonate in wildlife. *Environ Sci Technol* 35: 1339-1342
- Gilliland FD, Mandel JS. 1993. Mortality among employees of a perfluorooctanoic acid production plant. *J Occ Med* 35: 950-954
- Gilliland FD, Mandel JS. 1996. Serum perfluorooctanoic acid and hepatic enzymes, lipoproteins, and cholesterol: a study of occupationally exposed men. *Am J Ind Med* 29: 560-568
- Hansen KJ, Clemen LA, Ellefson ME, Johnson HO. 2001. Compound-specific, quantitative characterization of organic fluorochemicals in biological matrices. *Environ Sci Technol*, 35 (4), 766–770
- Haugom B, Spydevold O. 1992. The mechanism underlying the hypolipemic effect of perfluorooctanoic acid (PFOA), perfluorooctane sulphonic acid (PFOSA) and clofibrate acid. *Biochim Biophys Acta* 1128: 65-72
- Kannan K, Koistinen J, Beckmen K, Evans T, Gorzelany JF, Hansen KJ, Jones PD, Helle E, Nyman M, Giesy JP. 2001. Accumulation of perfluorooctane sulfonate in marine mammals. *Environ Sci Technol* 35: 1593-1598
- Kannan K, Franson JC, Bowerman WW, Hansen KJ, Jones PD, Giesy JP. Perfluorooctane sulfonate in fish-eating water birds including bald eagles and albatrosses. *Environ Sci Technol* 35: 3065-3070
- Kennedy GL Jr, Hall GT, Brittelli MR, Barnes, JR, Chem HC. 1986. Inhalation toxicity of ammonium perfluorooctanoate. *Food Chem Toxicol* 24: 1325-1329

Olsen GW, Gilliland FD, Burlew MM, Burris JM, Mandel JS, Mandel JH. 1998. An epidemiological investigation of reproductive hormones in men with occupational exposure to perfluorooctanoic acid. *J Occ Environ Med* 40: 614-622

Olsen GW, Burris JM, Mandel JH, Zobel LR. 1999. Serum perfluorooctane sulfonate and hepatic and lipid clinical chemistry tests in fluorochemical production employees. *J Occ Environ Health* 41:799-806

Reuber MD. 1978. Carcinogenicity of saccharin. *Environ Health Perspect* 25:173-200

Ubel FA, Sorenson SD, Roach DE. 1980. Health status of plant workers exposed to fluorochemicals, a preliminary report. *Am Ind Hyg Assoc J* 41: 584-589

Williams GM, Whysner J. 1996. Epigenetic carcinogens: evaluation and risk assessment. *Exp Toxicol Pathol* 48: 189-95